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(54) Title: COMPOSITIONS OF POLYCYCLOALKENYL-TERMINATED, UNSATURATED POLYESTERS OR POLYESTERAMIDES AND VINYL-REACTIVE PLASTICIZERS THEREFOR (57) Abstract Polycycloalkenyl-terminated, unsaturated polyesters or polyesteramide compositions, including or not including non-resinous vinyl monomers, are flexibilized by incorporation in the uncured composition of vinyl-terminated urethane oligomers comprising at least one polyglycol unit.		

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COMPOSITIONS OF POLYCYCLOALKENYL-TERMINATED,
UNSATURATED POLYESTERS OR POLYESTERAMIDES
AND VINYL-REACTIVE PLASTICIZERS THEREFOR

U.S. Patents 4,148,765 and 4,233,432 disclose dicyclopentadiene-modified, unsaturated polyesters. The latter esters have good properties in other respects but are inherently low in tensile strength, percent
5 elongation, impact strength and ductility; this is true also of the polyesteramides disclosed in the above-identified applications. If the several foregoing types of polyesters could be improved in the latter regards, while largely retaining their other properties,
10 this would be highly significant to certain applications - such as, for example, pultrusion-formed, oil well sucker rods.

U.S. Patent 3,297,745 discloses, as homo- and copolymerizeable "monomers", certain oligomeric urethane
15 chains capped with vinyl-terminated end groups. A copolymer derived from styrene, an allyloxy-terminated oligomer and a methacryloxy-terminated oligomer is stated to have had higher tensile and flexural moduli than homopolymers of any of the three monomers.

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U.S. Patent 4,360,653 discloses impact-resistant polymerizates of the latter types of oligomers with allyl carbonates of polyols.

U.S. Patent 4,390,662 (Ando et al; June 28, 1983; effective reference date March 25, 1981) teaches toughening of polyester and vinyl ester resins (vinyl esters plus styrene) with unsaturated polyurethanes prepared by reacting 1 molecular proportion of an organic diol with from 0.7 to 1 molecular proportion of a diisocyanate and capping the resulting adduct with 2 molecular proportions of a hydroxyalkylacrylate. The Ando polyurethanes have molecular weights corresponding to "weight-average molecular chain extensions, calculated as polystyrene," of from 100 to 1500Å, preferably from 200 to 1000Å, most preferably from 300 to 1000Å. That is, the rectilinear length of an unstraightened polystyrene molecule having a molecular weight equal to the weight average molecular weight of the polyurethane is from 100 to 1500Å, etc. A length range of from 100 to 1000Å corresponds to a molecular weight range of from about 22,295 to about 2,229,500.

The patent teaches that in order to be an effective toughener, the polyurethane must phase out upon curing of polyester/styrene/urethane compositions (but must not phase out upon curing of vinyl ester/-styrene urethane compositions).

Thus, the patent teaches away from the use of oligomeric urethanes for toughening of either polyester or vinyl ester resins. It also teaches away from toughening of polyester resins with urethanes which do not phase out upon curing.

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The term "polycycloalkenyl" as used herein is intended to designate a polycyclic hydrocarbon radical containing a reactive, cycloolefinic double bond; for example, a radical derived from the dimer of cyclopentadiene may be designated as a "tricyclodecenyl" radical and a norbornenyl radical may be designated as a "dicycloheptenyl" radical.

The term "urethane oligomer" (or "oligomeric urethane") is used herein to designate polymeric molecules made up of "polyglycol" and "urethane" units (as defined in detail subsequently herein) and having weight average molecular weights of less than 22,000; preferably, less than 9400.

For convenience, the unmodified term "alkyd" is used herein to designate both polyesters and polyesteramides, per se, whereas the term "alkyd resin" is intended to refer to mixtures of the alkyds and vinyl monomers (such as styrene, for example).

The symbol =NH is used herein to represent -NH₂ or NHR groups (R being defined later herein) or divalent NH groups in which the N is a member of a heterocyclic ring.

The primary object of the present invention is to improve the ductility, percent elongation, impact strength and tensile strength of polycycloalkenyl-terminated, unsaturated polyesters and polyesteramides while largely retaining the other properties thereof; i.e., to "flexibilize" them without adversely effecting them otherwise.

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A further object is to provide for attainment of the primary object in a direct and simple manner, as by mixing the subject polyester alkyds with vinyl-terminated, oligomeric urethanes - which do not phase out when the mixture is cured.

An additional object is to utilize certain known, readily made types of urethane oligomers as the latter flexibilizers.

A principle object is to provide flexibilized, cured compositions of polycycloalkenyl-terminated polyesters or polyesteramides with vinyl monomers, such as - for example - styrene and various acrylate monomers.

Still other objects will be made apparent to those knowledgeable in the art by the following specifications and claims.

The term "composition" therein is intended to apply to mixtures of the polyesters or polyesteramides and the oligomers which do or do not include vinyl monomers. Broadly, the process of the invention is to mix together the foregoing components of the compositions.

More particularly, the present invention resides in a curable, flexibilized polyester composition comprising, in admixture:

- a. an unsaturated polyester- and/or polyesteramide-alkyd having at least one polycycloalkenyl end group and optionally including a polyglycol-derived flexibilizing group, and

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- b. a flexibilizing, polyglycol moiety-comprising urethane oligomer having (1) two or more terminal groups, at least one of which is vinyl-reactive, and (2) a weight average molecular chain extension, calculated as polystyrene, of less than 100A,

5 the parts by weight of said oligomer per hundred parts of said alkyd being such that the oligomer will not phase out when said composition is cured and being
10 within the range of from about 1 to about 60 when the alkyd includes said flexibilizing group but being about 20 or less when the latter group is not included in the alkyd.

15 Dicyclopentadiene-modified, unsaturated polyesters represent a relatively new class of polyesters which, as alkyd resins, have improved economics and many highly useful properties, such as low shrinkage upon curing and excellent resistance to corrosion by aqueous media.

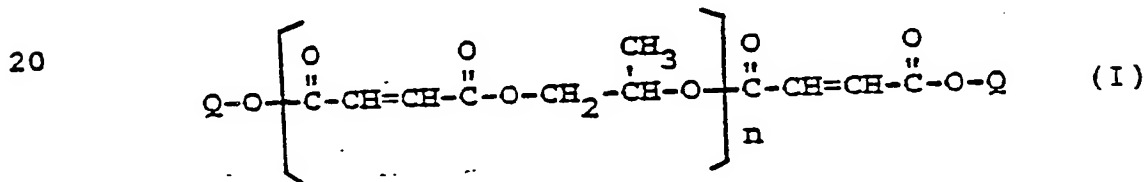
20 The new class of polyester alkyds represented by the unsaturated polyesteramides of the above-referenced applications exhibit (as the alkyd resins) not only the desirable properties of the known dicyclopentadiene-
25 -modified polyesters but also exhibit improved reactivity, excellent resistance to organic solvents, excellent electrical insulating properties and excellent resistance to thermal aging.

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Both of the foregoing classes of alkyd resins tend to be inherently low in tensile strength, impact strength, percent elongation, ductility and, to a lesser extent, in flexural strength. Only a limited improvement is realized when the known ploy of using mixed glycols or glycol ethers is employed in forming the dicyclopentadiene (or cyclopentadiene) - modified polyesters or polyesteramides. However, it has now been found that mixtures of the latter types of resins with vinyl-terminated urethane oligomers ("vinyl reactive plasticizers" or VRP's) provide cured compositions possessing substantially improved mechanical properties.

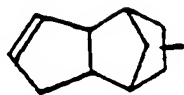
Polycycloalkenyl-terminated, unsaturated polyesters and polyester amides.

Representative of one type of polyester component of the present invention are those derived (predominantly) from maleic acid and propylene glycol. These may be depicted by the ideal or statistical structure,



wherein Q, in at least one occurrence, is a polycycloalkenyl radical such as, for example, a tricyclodecenyl or bicycloheptenyl radical, i.e.,

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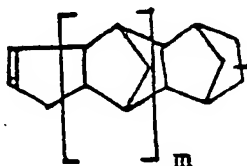
(a)

or



(b)

or is a radical of the formula

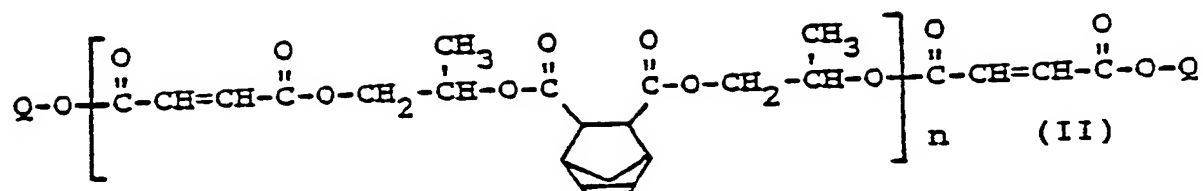


(c)

for example; when Q is not a polycycloalkenyl radical in the second occurrence, it may be -OH, =NH or -COOH. Preferably, Q is a polycycloalkenyl group in both occurrences, in at least a major proportion of the alkyd molecules, and m and n are integers from 1 to 10 and 1 to 100, respectively.

Representative of another type of polyester component of the present invention are those derived in part from maleic acid, endomethylenetetrahydrophthalic acid, and propylene glycol. The endomethylenetetrahydrophthalic acid groups may be incorporated by partial replacement of maleic acid therewith or by generation in situ by Diels-Alder reaction of cyclopentadiene (derived from dicyclopentadiene) and maleic anhydride. These alkyds may be depicted by the ideal or statistical structure,

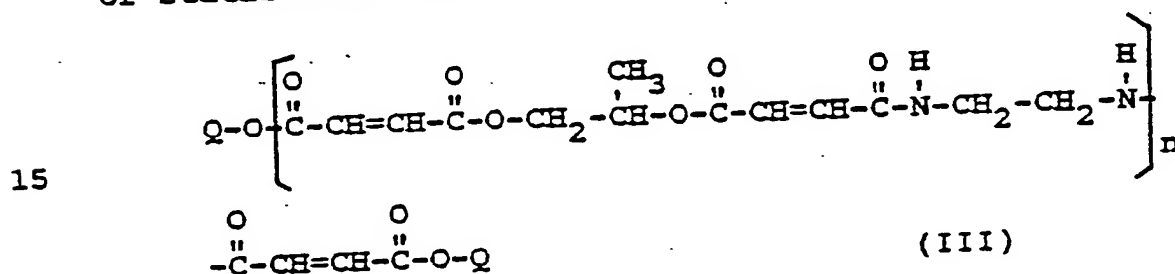
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wherein Q, m and n have the same meanings as in structure I.

- 5 Again, Q is preferably a polycycloalkenyl group in both occurrences, in at least a predominant proportion of the alkyd molecules.

10 Representative of one type of the polyester-amide component of the present invention are those deriveable from maleic acid, propylene glycol and ethylene diamine. These may be depicted by the ideal or statistical structure



- 20 wherein Q, m and n have the same meaning as in structure I. Again, Q is preferably a polycycloalkenyl group in both occurrences, in at least a predominant proportion of the alkyd molecules.

25 In each of the foregoing types of structures (I, II and III) the polycycloalkenyl radicals in a given molecule or in different molecules do not have to be the same. For example, when dicyclopentadiene is employed to modify a polyester, it can react by addition of a double bond with an alcoholic or carboxylic -OH

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group (preferably the latter) to form a terminal group of formula (a); however, it can also "crack" to provide monomeric cyclopentadiene which in turn can form Diels-Alder adducts with dienophilic carbon to carbon double bonds - such as are present in maleic anhydride, maleic acid and polycycloalkenyl end groups. Termination with the above type (b) group may result from in-situ formation of endomethylenetetrahydrophthalic anhydride. Type (c) end groups may form by successive additions of cyclopentadiene to a type (a) group.

Although dicyclopentadiene (as a commercial "DCPD concentrate") is the modifier of economic choice, incorporation of terminal polycycloalkenyl radicals of types other than the preceding (a), (b) and (c) groups is not ruled out. In fact, such other groups may be derived from components of DCPD concentrates other than DCPD itself, such as - for example - a cyclopentadiene co-dimer, an isoprene dimer or the trimers of cyclopentadiene (pentacycloalkadienes which react to form a pentacycloalkenyl radical).

Other examples of precursors to polycycloalkenyl radicals are the Diels-Alder adducts of: (1) butadiene, isoprene or cis- or transpiperylene with dicyclopentadiene, (2) butadiene, isoprene, a piperylene or cyclopentadiene with bicyclo[2,2,1]hepta-2,5-diene and (3) cyclohexadiene-1,3 with butadiene, isoprene, a piperylene, cyclopentadiene or itself.

Toluene sulfonic acid-catalyzed addition of -COOH groups to the afore-named bicycloheptadiene to form esters is known. The products consist predominantly of saturated esters having a nortricyclene structure

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but also include substantial amounts of the bicycloheptenyl esters. Reaction of a carboxyl end-group in a polyester moiety with one of the double bonds in the bicycloheptadiene should then result in production of a substantial content of bicycloheptenyl terminations.

Thus, di- to decacycloalkenyl terminal groups may be introduced in the polyester or polyesteramide components of the present invention by utilizing a variety of known types of alicyclic diolefins. Polycycloalkadienes of more than five (fused) rings can be utilized but are considered definitely less desirable.

An alternative method of incorporating dicyclopentadiene or norbornene moieties is to esterify an alcoholic hydroxyl-terminated polyester/esteramide chain with a dicyclopentadiene acrylic acid, 5-norbornene-2-acrylic acid or the Diels-Alder adduct of cyclopentadiene with acrylic acid. In still another method, the norbornene group may be incorporated by reaction of a carboxyl-terminated polyester moiety with 5-norbornene-2-ol or dicyclopentadiene monoalcohol.

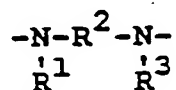
The polycycloalkenyl-terminated polyesters suitable for the practice of the present invention are then those which are deriveable from cyclic diolefins, difunctional carboxylic acids and polyols, and include at least one polycycloalkenyl end group and another end group which is an -OH, =NH, -COOH or polycycloalkenyl group; said acid consisting at least partially of an α, β -unsaturated diacid and any remainder consisting of saturated aliphatic acid(s), aromatic acid(s) or mixtures thereof and said polyol being of the formula $\text{HO-R}^4\text{-OH}$, as subsequently defined herein.

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The latter polyesters are generally preparable by the methods disclosed in U.S. Patents 4,189,548; 4,167,542 and 4,148,765 for making dicyclopentadiene-modified polyesters. The latter methods may be modified according to the foregoing discussion of ways of introducing polycycloalkenyl groups other than those deriveable directly from dicyclopentadiene (or cyclopentadiene) per se.

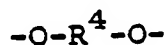
The polycycloalkenyl-terminated polyester-amides employed in the present invention are those having a central esteramide chain comprising:

(a) diamino groups of the formula:



wherein R^1 and R^3 are independently selected from hydrogen, aliphatic, cycloaliphatic and aromatic or R^1 and R^3 together form an aliphatic ring, and R^2 is a divalent organic radical selected from alkylene, oxy-linked alkylene, oxy-linked arylene, alkylene amino-linked alkylene, alkylene amino-linked cycloalkylene, cycloalkylene, polycycloalkylene, arylene, alkylarylene bis(alkyl)cycloalkylene and bis(alkyl)polycycloalkylene,

(b) dioxy groups of the formula:



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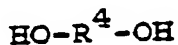
wherein R^4 is a divalent organic radical selected from alkylene, oxy-linked alkylene, oxy-linked arylene, cycloalkylene, polycycloalkylene, bis(alkyl)cycloalkylene, bis(alkyl)-polycycloalkylene, and arylene, and mono- to trihydroxy alkylene;

and

- (c) diacyl residues of difunctional carboxylic acids, at least a part of said acids being α, β -unsaturated acids and any remainder being saturated aliphatic acids, aromatic acids or mixtures thereof.

Typical diamine components of the foregoing polyesteramides are ethylene diamine, propylene diamine, hexane-1,6-diamine, piperazine, 4,4'-methylenebis-(cyclohexylamine), 2,2'-bis(4-aminocyclohexyl)propane, 4,4'-diaminodiphenyl ether, bis(aminomethyl)norbornane, toluene diamine, bis(aminomethyl)dicyclopentadiene and homopiperazine. Typical polyamines are aminoethyl-piperazine and diethylenetriamine.

The polyol component of the polyester or polyesteramide is from the class having the formula:



wherein R^4 is as above defined. Mixtures of two or more such polyols can be used.

Representative such polyols are ethylene glycol, propylene glycol, diethylene glycol, dipropylene

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glycol, dicyclopentadiene dimethanol, bis(hydroxymethyl)-norbornane, methyl cyclohexanedimethanol, bis(hydroxypropyl)bisphenol A and other hydroxyalkylated bisphenols, pentaerythritol, sorbitol and glycerine.

5 When a polyesteramide is to be used, the ratio of diamine to polyol therein can be varied within wide limits. The latter ratio is significantly related to the solubility of the modified polyesteramide in reactive diluents, such as styrene, which are commonly
10 employed with polyesteramides for many applications. As a general rule, the moles of diamine should not exceed about 1/3 the combined moles of the polyol and diamine. The structure and size of the diamine molecule will determine to great extent the maximum amount
15 of diamine that can be used.

The unsaturated polycarboxylic acid component of the polyester or polyesteramide preferably is largely composed of an α,β -unsaturated acid, such as maleic acid, fumaric acid, maleic anhydride or mixtures of
20 those compounds. The latter acids are readily available, have good reactivity with the polyol and/or diamine, and result in products of good properties.

Part of the α,β -unsaturated acid may be further replaced with a saturated or aromatic polycarboxylic acid to vary the cross-linking potential and
25 physical properties of the modified polyester or polyesteramide. Such acids include the aliphatic acids such as adipic acid and the aromatic acids such as isophthalic acid. Replacement of part of the α,β -unsaturated acid with such acids is commonplace in the
30 polyester art. Suitable selection of the acid and

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the amount thereof to achieve a desired purpose will be known to the skilled worker and can be optimized with simple preliminary experiments.

When endomethylenetetrahydrophthalic acid or anhydride is used, it may be prepared separately or in situ by known methods. Furthermore, it may be composed totally or partially of the corresponding methyl endomethylenetetrahydrophthalic anhydride.

The modified polyesteramides can be prepared by a variety of techniques. In one of the most preferred methods, hereinafter called the "hydrolysis method," an α, β -unsaturated polycarboxylic anhydride and/or acid is partially hydrolyzed with less than the stoichiometric equivalent of water and reacted with less than or equal to the stoichiometric equivalent of the dicyclopentadiene derivative to form a product containing the esterified derivative, any (preferably no) unreacted derivative and the unesterified acid and anhydride. This reaction may conveniently be performed in stages whereby reactants are added stepwise, thus controlling exotherms. The resulting reaction mixture is then reacted with the polyol and diamine to produce the desired modified polyesteramide.

In a typical procedure, molten maleic anhydride and a fraction of the stoichiometric equivalent of water are maintained at an elevated temperature of from 60° to 130°C. The initial fractional equivalent of dicyclopentadiene (DCPD) is then added and allowed to react. A second fractional equivalent of water and of DCPD is added and allowed to react. Additional fractional equivalents of DCPD are added and

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each allowed to react before subsequent addition of the next increment until the desired amount of DCPD has been added. The number of fractional equivalents can be increased and the increment size accordingly decreased to afford any desired number of increments. If desired, the DCPD addition can be continuous. Optionally, the relative sizes of successive increments or the rate of continuous addition may vary.

To the mixture of esterified DCPD, unreacted α, β -unsaturated polycarboxylic acid and/or anhydride, is added the polyol and diamine. The addition can be a bulk addition wherein all of the polyol and diamine are added in one step. Alternatively, the addition can be an incremental addition wherein all of the polyol and a fractional equivalent of the diamine are added initially and allowed to react after which subsequent increments of diamine are added. In all instances, water is continuously removed during the esteramidation step. The timing of the remaining diamine additions can be easily determined by the amount of water removed, by acid number and/or by viscosity. A convenient and practical guide is to add a diamine increment when about one fourth to one half of the expected water from the reaction has been collected. Incremental diamine addition aids in the control of reaction exotherm when certain diamines are used.

After addition of the polyol and diamine is complete, the reaction can be driven to maximum yield by maintaining or increasing the temperature, preferably from 160° to 205°C, until the desired acid number has been reached. Typically, acid numbers of 15 to 35 are preferred, although acid numbers that are somewhat

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higher or lower may be tolerated, and, in some instances, may be desired for certain applications.

In an equally preferred method, hereinafter called the "prehydrolysis method", an α,β -unsaturated polycarboxylic anhydride is essentially totally hydrolyzed with a stoichiometric or greater equivalent of water and reacted with less than or equal to the stoichiometric equivalent of the dicyclopentadiene derivative to form a product containing esterified dicyclopentadiene derivative, the unreacted derivative (if any), and the unesterified acid. This reaction may conveniently be performed in stages whereby reactants are added stepwise, thus controlling reaction exotherms. The product mixture is then reacted with the polyol and diamine as earlier mentioned to result in the desired modified polyesteramide.

In a typical procedure, molten maleic anhydride and the stoichiometric or greater equivalent of water are maintained at an elevated temperature of from 60° to 130°C. The temperature is allowed to stabilize at 120° to 125°C and the initial fractional equivalent of DCPD is then added and allowed to react. A second fractional equivalent of DCPD is then added and allowed to react. Additional fractional equivalents of DCPD are added and each allowed to react, before subsequent addition of the next increment, until the desired amount of DCPD has been added to the product mixture.

The polyol and diamine are added to the mixture of esterified DCPD and acid as described in the aforementioned hydrolysis method.

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In a preferred method, hereinafter called the "direct method," maleic anhydride and/or acid and the desired amount of DCPD are reacted at an elevated temperature to form endomethylenetetrahydrophthalic anhydride. After cooling the reaction mixture, the unreacted maleic anhydride is hydrolyzed with less than, equal to or greater than the a stoichiometric equivalent of water and reacted with additional dicyclopentadiene derivative to form a product containing an esterified DCPD derivative and unesterified acids and/or anhydrides. This reaction may conveniently be performed in stages whereby reactants are added stepwise, thus controlling reaction exotherms. The product mixture is then reacted with the polyol and diamine as earlier mentioned to result in the desired modified polyesteramide.

In a typical procedure, molten maleic anhydride and the desired amount of DCPD are maintained at an elevated temperature of from 130° to 170°C to form endomethylenetetrahydrophthalic anhydride. The temperature is then allowed to stabilize at 60° to 130°C and a fractional equivalent of water is added. A fractional equivalent of DCPD is added and allowed to react. A second fractional equivalent of water and of DCPD is added and allowed to react. Additional fractional equivalents of DCPD are added and each allowed to react before subsequent addition of the next increment until the desired amount of DCPD has been added.

The polyol and diamine are added to the mixture of esterified DCPD and acids and/or anhydrides as described in the aforementioned hydrolysis method.

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When a dicyclopentadiene concentrate containing
piperylene and/or isoprene codimers of cyclopentadiene
is used, dedimerization of said codimers followed by
subsequent reaction of piperylene and/or isoprene with
5 maleic anhydride and/or acid leads to formation of
methyl tetrahydrophthalic anhydrides and/or acids. The
methyl tetrahydrophthalyl groups are incorporated into
the esteramide chains in a manner identical to that of
the endomethylenetetrahydrophthalyl groups. If methyl-
10 dicyclopentadiene is used, methyl cyclopentadiene will
form, resulting in formation of Diels-Alder adducts
thereof.

In a further modification of either the
hydrolysis, prehydrolysis or direct method, a polyol
15 containing 3 or more hydroxyl groups such as penta-
erythritol may be separately added to the reaction
after polyesteramidation is substantially complete.
This serves to rapidly increase molecular weight and
viscosity by cross-linking of the esteramide chains.
20 Modified physical properties result from this embodiment.

Many other alternate methods will be apparent
to the skilled worker. For example, molten maleic
anhydride may be added to a mixture of DCPD and water
maintained in a reactor. The polyol and diamine can
25 then be added to the mixture of esterified DCPD and
acids and/or anhydrides as before. Finally, although
less preferred, DCPD, maleic anhydride, water, glycol,
and none, all or part of the diamine may be simultaneously
reacted.

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Vinyl Reactive Plasticizer Constitution

The VRP component of the composition of the invention is a polyglycol moiety-comprising urethane oligomer having end groups of which at least one is vinyl-reactive (i.e., contains a polymerizeable carbon-to-carbon double bond).

The oligomers of this type disclosed (as "monomers") in the aforementioned '745 and '653 patents are generally suitable for the practice of the present invention. Similar oligomers in which the end groups are incorporated as hydroxyalkyl acrylate-initiated polyglycols, rather than as the hydroxyalkyl acrylates per se, are not only suitable but advantageous in the VRP role.

Also suitable VRP's are the bis(N-vinylcarbamates) formed by the reaction of an unsaturated isocyanate with a polyglycol. Suitable such isocyanates are vinyl isocyanate and isopropenyl isocyanate - as disclosed in U.S. Patent 3,598,866; see Example 8 therein. Similarly, polyadducts of isocyanatoethyl methacrylate, allyl isocyanate, allyl isothiocyanate or allyl glycidyl ether with polyglycols also may be used as the VRP component.

The VRP component of the compositions of the invention alternatively may be of the novel type described in U.S. Patent No. 4,486,582 issued December 4, 1984. This type of VRP is prepared by the reaction of a vinyl- or acryloxy-substituted phenol or phenol-initiated polyol with at least one of the terminal isocyanate (or isothiocyanate) groups in a urethane oligomer formed by reaction of an excess of a difunctional isocyanate

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(or thiocyanate) with a polyol. The preferred vinyl-substituted phenol for this purpose is phenol itself, substituted by an isopropenyl group. However, such other phenols as cresols ring-substituted with ethenyl, allyl or isopropenyl groups are also suitable and the polyol portion of the molecule may be terminated by an $-NH_2$ group.

The most generally suitable and economic VRP's presently known of are products of (1) a diisocyanate, (2) a hydroxy- or aminoalkylacrylate and (3) a polyglycol or amino-capped polyglycol. In these VRP's, the alkyl portion of the hydroxy- or aminoalkylacrylate may be interrupted by one or more oxygen or sulfur atoms; i.e., the hydroxy-substituted acrylate may be a monoacrylate of diethylene- or tripropylene glycol, for example. Also, N-methylol acrylamide may be employed in place of a hydroxyalkylacrylate as a source of vinyl end groups in such VRP's.

In each of the several foregoing types of unsaturated adducts, the polyglycol moiety preferably is derived from a diol (by base catalyzed reaction with an alkylene oxide) but desirably is based on (initiated with) a triol - such as glycerine or triethanol amine, for example -, an aminoalcohol or a polyfunctional amine. Since isocyanates will react with $-NH$, as well as with $-OH$ (or $-SH$) groups, the polyglycol unit(s) may be amino-capped and/or the $-OH$ function in an end group precursor - such as 2-hydroxypropyl methacrylate, for example - may be replaced by an $-NH_2$ function.

A type of VRP particularly preferred for use with alkyds which include a flexibilizing moiety in

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their structure is one in which the polyglycol component is derived from a triol - such as glycerine, for example, and an alkylene oxide - such as propylene oxide, for example. Quite dramatic results have been obtained when the polyol component of the VRP and the flexibilizing moiety in the alkyd are the same. See Example 10 herein, where propoxylated glycerine was incorporated in both the alkyd and the VRP.

Preferably, the VRP has at least two vinyl-
-reactive end-groups. However, this is not indispensable; VRP's having only one vinyl-reactive end group are considered suitable for the practice of the present invention. On the other hand, a total of three "terminal" vinyl groups (resulting from use of a triol-based polyglycol) is considered advantageous.

All ramifications of the VRP component are of course within the constraint that the VRP exhibit the requisite compatibility with the other components (the polyester or polyester and vinyl monomer components) of the cured composition of the invention. This can readily be checked for any candidate VRP, without undue experimentation, in a manner which will be apparent to those knowledgeable in the art.

For the purposes of the present invention, the urethane oligomers employed have weight average molecular chain extensions, calculated as polystyrene, of less than 100Å, preferably less than 65Å. The latter values correspond, respectively, to weight average molecular weights of less than 22,000 and preferably less than 9400. A particularly preferred class of oligomers are those which have weight average molecular weights of less than 8000.

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Most preferred among the latter are those oligomers prepared from one molecular proportion of an about 2000 molecular weight polyglycol, about 1.7-2 molecular proportions of a monomeric diisocyanate and about 2 molecular proportions of a hydroxyalkyl acrylate or methacrylate, in either of two reaction sequences. That is, the glycol and isocyanate are reacted with each other before the acrylate is introduced or the acrylate and isocyanate are first reacted with each other and the glycol is then introduced (thereby minimizing the molecular weight of the oligomer formed). A typical urethane oligomer made by pre-reacting 2.4 moles of tolylene diisocyanate with 1.2 moles of polypropylene glycol (mol wt. 2000) and then reacting in 2.40 mols of hydroxyethyl acrylate (2/2/1 ratio), was found to have a weight average molecular weight of 7681. When 0.8 mole of the same isocyanate was pre-reacted with 0.8 mols of the same acrylate and then 0.4 mols of the same glycol reacted in, the oligomer obtained had a weight average molecule weight of 5132.

A type of VRP found particularly suitable for use with internally flexibilized alkyds is one in which the polyglycol is a hydroxyalkylated triol - such as propoxylated glycerine, for example. Such polyglycols have substantially higher molecular weights but the VRP's prepared from them according to the methods disclosed herein still have molecular weights well below 22,000.

Methods of Preparation of VRP's

The vinyl terminated urethane oligomers disclosed in U.S. Patents 3,297,745 and 4,360,653 are generally suitable for use as VRP's in the present

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invention and may be prepared by the several methods disclosed in said patents.

The latter methods are also generally applicable to the preparation of VRP's in which the terminal
5 unsaturation is derived from a hydroxyacrylate-initiated polyol or a phenol-initiated polyol in which the phenol is ring-substituted with an alkenyl group. (See Example J herein.)

Preparation of VRP's by the reaction of an
10 unsaturated isocyanate, such as isopropenyl isocyanate, allyl isothiocyanate and isocyanatoethyl methacrylate, for example, with a polyglycol is exemplified herein and does not require any procedures unfamiliar to polyurethane chemists.

15 In preparing VRP's by the condensation of a hydroxy or aminoalkylacrylate, a diisocyanate and a polyglycol, whether the isocyanate is first reacted with the acrylate or the polyglycol is not critical. In either case, however, the reactant ratio in the
20 initial condensation must be controlled to insure the presence of the requisite, unconverted isocyanate end-groups in the intermediate product.

As indicated earlier herein, the reaction
sequence does effect and can be utilized to manipulate
25 the viscosity (average molecular weight) of the VRP. If the isocyanate is first reacted with the hydroxy-acrylate, the viscosity of the final product will be lower than when the isocyanate is first reacted with the polyol.

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VRP to Polymer Ratio

The weight ratio of the VRP to the polyester or polyesteramide in the compositions of the invention can range from 1/100 to 3/5; i.e., from 1 to 60 parts VRP per hundred parts of the alkyd, or 1-60 "phr". Except when the alkyd has incorporated in it a flexibilizing moiety - as part of the alkyd molecule - the VRP content should be within the range of from 1-20 phr and preferably is from 6 to 16 phr; the range of from 12 to 16 phr being particularly preferred. In any case, the content of VRP is such that essentially no "phasing", i.e., formation of a distinct, separate VRP phase, results when the composition is cured.

When the alkyd molecule does include a flexibilizing moiety, the content of the VRP is preferably within the range of from 41 to 59 phr.

Copolymerizable Vinyl Monomer

The compositions of the invention preferably comprise a non-resinous, vinyl reactive monomer - which preferably is styrene. Other, specific such monomers, for example, are vinyl toluene, t-butylstyrene, divinyl benzene and chlorostyrene. Various acrylates, as exemplified by dicyclopentadienyl acrylate, sec-butyl acrylate and ethylacrylate, though less preferred, are considered suitable for the practice of the present invention. Thus, suitable vinylic monomers generally are those commonly copolymerized with polymers having terminal or pendant, vinyl-reactive, olefinic or cyclo-olefinic double bonds. Such monomers are well catalogued in the prior art.

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The well known catalysts and procedures for the latter type of copolymerization are also generally applicable to "curing" (chain extension and cross-linking) of the compositions of the present invention which comprise vinyl monomers. Those compositions which do not include vinylic monomers are considered novel per se and may be cured by use of the same catalysts and procedures to thermoset products.

The vinyl monomer, frequently called a reactive diluent, may be employed within a wide range of concentration of from 20 to 80 percent of diluent to 80 to 20 percent of the polyester or polyesteramide (from 25 to 400 phr). The optimum amount will depend in large measure on the particular alkyd, the diluent and the properties desired in the uncured and the cured states. Reactive diluents are employed principally to adjust the viscosity of a resin blend to permit its facile use in a given fabrication procedure. A coating formulation will usually require a lower viscosity than a molding formulation. When the alkyd does not include a flexibilizing group, the preferred vinyl monomer content is from about 58 to about 68 phr. When the alkyd does include a flexibilizing group, from about 130 to about 150 phr of the monomer is preferred.

Other additives that are conventional in the polyester and polyesteramide art may also be included in formulations based upon these modified alkyds. Thus, fillers, pigments and other colorants, reinforcing fibers, and other additives may be added to serve their intended function.

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The modified polyesters and polyesteramides are curable by known catalyst systems. Peroxides, such as methylethylketone peroxides, can be used with or without known promoters, such as cobalt octoate or cobalt naphthenate, that function with such peroxides. Acyl peroxides, such as benzoyl peroxides can be used with or without promoters such as tertiary amines, including typically dimethyl aniline and N,N-dimethyl-p-toluidine. The concentrations of catalyst and promoter are adjusted within known limits of from 0.1 to 3.0 weight percent depending on the rate of cure desired, the magnitude of the generated exotherm and for other known purposes. Known gelation retarding agents, such as p-benzoquinone, can be employed in the curing system.

The compositions of the present invention have properties that make them well adapted for molding, casting, pultrusion, filament winding and other known fabrication procedures. A preferred use is in fabricated parts where improved toughness is necessary yet a high degree of corrosion resistance, heat resistance and electrical insulating ability are still required. Typical of these applications are pultrusion-formed, oil well sucker rods as well as molded parts for exterior automotive use or use in electrical transformer housings.

The uncured compositions of the invention which do not include vinyl monomers (such as styrene, for example) have utility as intermediate materials which can be mixed with such monomers and cured.

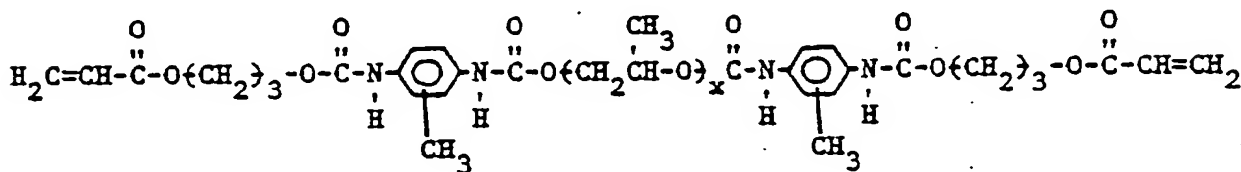
Examples

The following examples are for purposes of illustration and are not be construed as limiting the present invention in a manner inconsistent with the claims appended to these specifications.

Those material names capitalized in the examples are registered trade names.

A. Preparation of a VRP from a polypropylene glycol, toluene diisocyanate and hydroxypropylacrylate.

A VRP having the statistical structure (III)



$$x = \sim 34$$

was prepared in two steps; the polyglycol was reacted with the diisocyanate, in the presence of stannous octoate, until the -OH band in the infrared (IR) spectrum of the reaction mixture disappeared and the hydroxyacrylate was then added to react out the remaining isocyanate groups. The detailed procedure follows.

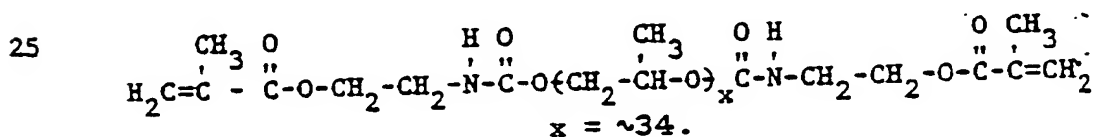
A 0.12 percent solution of stannous octoate (3.355 grams) in 2811.12 grams (1.4056 g moles) of polypropylene glycol (DOW: P-2000) was added over a period of about 1 3/4 hours to 488.4 grams (2.8111 g moles) of toluene diisocyanate (Type I, NACONATE 80; registered trade name of The Dow Chemical Company) 80/20 mixture of 2,4- and 2,6-isomers) in a 5-liter resin flask fitted with a reflux condenser and stirrer.

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The flask contents were heated from an initial temperature of 60°C to a final temperature of 70°C, during the addition. Stirring was continued at the latter temperature for another 3/4 hour, at which time the -OH infrared peak had disappeared. A preformed solution of 1.815 grams of phenothiazine (vinyl polymerization inhibitor) in 330 grams (2.54 g moles) of 2-hydroxypropyl acrylate was then added and the resulting mixture stirred at a temperature of 82-86°C for an additional 2/3 hour, at which point no further decrease in isocyanate absorption (IR) or increase in carbonyl absorption was observable. The product, designated herein as VRP-A, had a Gardner viscosity, at 20°C, equivalent to 79,200 cps. (Acrylate/diisocyanate/glycol mole ratio 1.8/2/1.)

15 B. Preparation of VRP's from isocyanatoethyl methacrylate and a polyol.

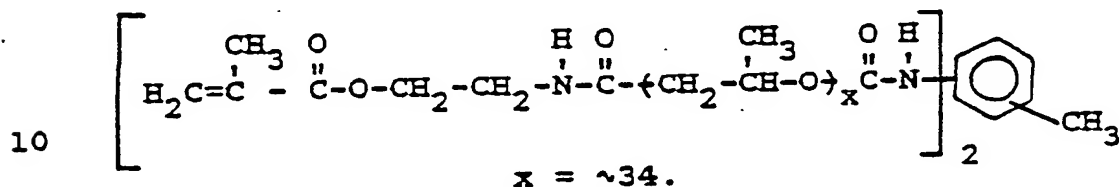
(1) 80.4 grams (0.52 g mole) of isocyanatoethyl methacrylate, 519.6 grams (0.26 g mole) of P-2000, 0.66 grams of stannous octoate (catalyst) and 0.05 gram of phenothiazine (vinyl stabilizer) were stirred together in a round-bottomed flask for 3 hours. The reaction proceeded, to completion, spontaneously. The resultant VRP exhibited a low viscosity and had the statistical structure IV:



(2) A higher molecular weight VRP was made in two steps. 25.2 Grams (0.145 g mole) of toluene diisocyanate (Type I NACONATE 80) was added slowly to a solution of

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0.69 gram of stannous octoate in 574.8 grams (0.2874 g mole) of P-2000. After stirring for several hours, the resulting glycol-extended diurethane was reacted with 44.5 grams (0.287 g mole) of isocyanatoethyl methacrylate as in (1) above. The resultant VRP was substantially more viscous than that obtained in preparation B-(1) and had the statistical structure V:



C. Preparation of dicyclopentadiene-modified, unsaturated polyesteramide alkyd.

Maleic anhydride (7.0 moles, 686.42 grams) was added to a reactor and heated to 100°C under a nitrogen atmosphere. Water (7.10 moles, 127.94 grams) was added inducing a maximum exotherm of 134°C one minute later. Fifteen minutes after the initial water addition, the reactor was air cooled to 120°C and dicyclopentadiene concentrate (2.10 moles, 278.70 grams) was added. The DCPD concentrate contained 0.31 percent lights, 13.64 percent cyclopentadiene codimers and diolefin dimers, and 86.05 percent DCPD. A maximum exotherm to 125°C resulted three minutes later. Air cooling reduced the reactor temperature to 120°C. A second aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added fifteen minutes after the initial DCPD concentrate addition. Fifteen minutes later, a final aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added and the 120°C reaction temperature was re-achieved three minutes later. After thirty minutes,

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propylene glycol (3.78 moles, 287.66 grams) and piperazine (0.420 moles, 36.18 grams) were added to the reactor and the steam condenser was started, nitrogen sparging was increased to four liters per minute, and the temperature controller was set at 160°C. The 160°C temperature was reached twenty-two minutes later. After two hours at 160°C, the temperature controller was set at 205°C and this temperature was achieved twenty-five minutes later. After ten hours, a total of 157.5 milliliters of water layer and 46.5 milliliters of organic material had accumulated in a Dean Stark trap. The reactor contents were cooled to 168°C and 100 ppm of hydroquinone was added. The modified polyesteramide alkyd was recovered as a clear, light yellow-colored solid with a final acid number of 26.4.

D. Modification of polyesteramide by a prior art flexibilizing technique, i.e. - using equimolar mixture of propylene and dipropylene glycols as the glycol component.

A dicyclopentadiene modified unsaturated polyesteramide was prepared using an equimolar propylene glycol and dipropylene glycol mixture. Specifically, the reaction was performed as follows:

Maleic anhydride (7.0 moles, 686.42 grams) was added to a reactor and heated to 100°C under a nitrogen atmosphere. Water (7.10 moles, 127.94 grams) was added inducing a maximum exotherm of 134°C one minute later. Fifteen minutes after the initial water addition, the reactor was air cooled to 121°C and dicyclopentadiene concentrate (2.10 moles, 278.70 grams) was added. The DCPD concentrate contained 0.31

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percent lights, 13.64 percent cyclopentadiene codimers and diolefin dimers, and 86.05 percent DCPD. A maximum exotherm of 130°C resulted three minutes later. Air cooling reduced the reactor temperature to 120°C. A
5 second aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added fifteen minutes after the initial DCPD concentrate addition. Fifteen minutes later, a final aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added and the 120°C reaction temperature was
10 re-achieved three minutes later. After thirty minutes, propylene glycol (1.89 moles, 143.83 grams), dipropylene glycol (1.89 moles, 253.60 grams), and piperazine (0.420 mole, 36.18 grams) were added to the reactor and the steam condenser was started, nitrogen sparging was
15 increased to four liters per minute, and the temperature controller was set at 160°C. The 160°C temperature was reached twenty-eight minutes later. After two hours at 160°C, the temperature controller was set at 205°C and this temperature was achieved thirty-four minutes
20 later. After ten hours, a total of 182 milliliters of water layer and 49.5 milliliters of organic material had accumulated in the Dean Stark trap. The reactor was cooled to 168°C and 100 ppm of hydroquinone was added. The modified polyesteramide alkyd was recovered
25 as a clear, light yellow-colored solid with a final acid number of 25.6.

Example 1 - Comparison of flexibilizing technique of the present invention with that of the prior art.

An uncured composition of the present invention
30 was formulated by combining a portion of the foregoing polyesteramide C with styrene and VRP-A in the relative amounts of 57.0, 35.5 and 7.5 wt. percent's, respectively. A clear solution was obtained.

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For comparison, formulations containing 57.0 percent alkyd and 43.0 percent styrene were made up from each of the foregoing alkyds C and D.

5 The three resin formulations were tested to
determine SPI gel and cure characteristics (84°C) and
Brookfield viscosity (25°C); a clear, unfilled 3.2 mm
casting of each formulation was made for heat distortion
temperature, tensile and flexural strength, flexural
modulus, percent elongation, and average Barcol hardness
10 (934-1 scale) determinations. The clear castings were
prepared using a cure system of 1.0 percent benzoyl
peroxide and 0.05 percent dimethylaniline at room
temperature, followed by postcuring for 2.0 hours at
93°C (200°F). Mechanical properties of tensile (6) and
15 flexural (6) test pieces were determined using an
Instron machine with ASTM Test Methods O-638 and D-790.
Heat distortion temperatures were determined using an
Aminco Plastic Deflection Tester with ASTM test method
D-678. The results are reported in Table 1.

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TABLE 1

		<u>Alkyd C/Styrene</u>		<u>Alkyd D/Styrene</u>
		<u>With</u>	<u>Without</u>	<u>(Mixed glycols)</u>
		<u>VRP-A</u>	<u>VRP</u>	
5	Brookfield Viscosity (cp)	771	178	143
	SPI Gel Test			
	Gel time (min)	6.1	3.2	3.1
	Cure time (min)	8.5	5.0	5.3
	Maximum exotherm (°C)	174	210	221
10	Average Barcol Hardness	34.5	40.8	41.1
	Heat Distortion Temperature (°C)	97.8	107.2	105
	Tensile Strength (kPa)	44,000	21,860	24,000
	Elongation (%)	2.36	0.69	0.89
	Flexural Strength (kPa)	92,400	75,800	98,000
15	Flexural Modulus x 10 ⁻⁵ (kPa)	30.6	36.8	36.8

- It will be seen that a dramatically greater improvement in tensile strength and percent elongation was attained with the VRP than by using mixed glycols; the effect of the VRP on flexural strength was less than that of the mixed glycols but was still significant.

E. Preparation of dicyclopentadiene-modified, unsaturated polyester alkyd.

- Maleic anhydride (7.0 moles, 686.42 grams) was added to a reactor and heated to 100°C under a nitrogen atmosphere. Water (7.10 moles, 127.94 grams) was added inducing a maximum exotherm to 131°C three minutes later. Fifteen minutes after the initial water addition, the reactor was air cooled to 120°C and

5 dicyclopentadiene concentrate (2.10 moles, 278.70 grams) was added. The DCPD concentrate contained 0.31 percent lights, 13.64 percent cyclopentadiene codimers and diolefin dimers, and 86.05 percent DCPD. A maximum exotherm to 126°C resulted four minutes later. Air cooling reduced the reactor temperature to 120°C. A second aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added fifteen minutes after the initial DCPD
10 concentrate addition. Fifteen minutes later, a final aliquot of DCPD concentrate (2.10 moles, 278.70 grams) was added and the 120°C reaction temperature was re-achieved three minutes later. After thirty minutes, propylene glycol (4.20 moles, 319.62 grams), was added to the reactor and the steam condenser was started,
15 nitrogen sparging was increased to four liters per minute, and the temperature controller was set at 160°C. The 160°C temperature was reached twenty minutes later. After two hours at 160°C, the temperature controller was set at 205°C and this temperature was
20 achieved twenty-seven minutes later. After 4.25 hours, a total of 189.5 milliliters of water layer and 60.5 milliliters of organic material had accumulated in a Dean Stark trap. The reactor was cooled to 168°C and 100 ppm of hydroquinone was added. The modified polyester
25 alkyd was recovered as a clear, light yellow-colored solid with a final acid number of 25.8.

Example 2 - Flexibilizing effects of VRP on dicyclopentadiene-modified polyester alkyd.

30 An uncured composition of the invention was formulated from the alkyd E (57.0 wt. percent), styrene (34.0 wt. percent) and VRP-A (9.0 wt. percent). For comparison, a formulation without the VRP component was

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made up from the same alkyd (57.0 wt. percent) and styrene (43.0 wt. percent). The physical and mechanical properties of the two formulations were determined as in Example 1 and are reported in Table 2.

TABLE 2

		<u>ALKYD-E/STYRENE</u>	
		<u>With</u>	<u>Without</u>
		<u>VRP-A</u>	<u>VRP</u>
	Brookfield Viscosity (cp)	194	44
10	SPI Gel Test		
	Gel time (min)	9.72	5.1
	Cure time (min)	13.1	7.6
	Maximum exotherm (°C)	170	183
	Average Barcol Hardness	32.3	44.0
15	Heat Distortion Temperature (°C)	88.3	103.9
	Tensile Strength (kPa)	52,300	29,200
	Elongation (%)	3.48	1.16
	Flexural Strength (kPa)	101,400	72,800
	Flexural Modulus x 10 ⁻⁵ (kPa)	31.8	42.6

20 Again, a dramatic improvement in tensile strength percent elongation and flexural strength will be seen to have resulted from inclusion of the VRP.

F. Preparation of modified unsaturated polyester-
amide using higher purity (98 percent) dicyclopentadiene.

25 Maleic anhydride (7.0 moles, 686.42 grams) was added to a reactor and heated to 100°C under a nitrogen atmosphere. Water (7.10 moles, 127.94 grams) was added, inducing a maximum exotherm to 135°C one

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minute later. Fifteen minutes after the initial water addition, the reactor was air-cooled to 121°C and 98 percent dicyclopentadiene (2.10 moles, 277.64 grams) was added. A maximum exotherm to 125°C resulted two minutes later. Air cooling reduced the reactor temperature to 120°C. A second aliquot of dicyclopentadiene (2.10 moles, 277.64 grams) was added fifteen minutes after the initial dicyclopentadiene addition. A maximum exotherm to 127°C resulted four minutes later. Air cooling reduced the temperature of the reactor contents to 120°C. Fifteen minutes after the second dicyclopentadiene addition, a final aliquot of dicyclopentadiene (2.10 moles, 277.64 grams) was added and the 120°C reaction temperature was re-achieved two minutes later. After thirty minutes, propylene glycol (3.78 moles, 287.66 grams) and piperazine (0.420 moles, 36.18 grams) were added to the reactor and the steam condenser was started, nitrogen sparging was increased to four liters per minute, and the temperature controller was set at 160°C. The 160°C temperature was reached seventeen minutes later. After two hours at 160°C, the temperature controller was set at 205°C and this temperature was achieved twenty-five minutes later. After fourteen hours, a total of 175 milliliters of water layer and 27 milliliters of organic material had accumulated in a Dean Stark trap. The reactor was cooled to 168°C and 100 ppm of hydroquinone was added. The modified polyesteramide alkyd was recovered as a clear, light yellow-colored solid with a final acid number of 18.8.

30 Example 3 - Effect of VRP on impact strength of Alkyd F.
Portions of alkyd F were formulated with varying amounts of VRP-A and styrene to provide six

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different, uncured compositions of the present invention. Izod impact strengths were determined on unnotched, clear, unfilled 3.2 mm castings prepared at room temperature from each formulation using a cure system of 1.0 percent benzoyl peroxide and 0.05 percent dimethylaniline and then post-cured 2 hours at 93°C. Ten 6.35 x 1.27 x 0.32 cm test pieces were prepared from each casting and tested (ASTM method D256) using a TMI Impact Tester No. 43-1.

The compositions and impact strengths of the formulations are given in Table 3.

TABLE 3

15	Formulation			Izod Impact Strength (Unnotched) Joules/met.
	Alkyd F Wt. %/Grams	VRP-A Wt. %/Grams	Styrene Wt. %/Grams	
	57.0/85.5	None ^{1/}	43.0/64.5	42.72
	"	2.0/3.0	41.0/61.5	69.42
	"	4.0/6.0	39.0/58.5	80.10
20	"	7.0/10.5	36.0/54.0	133.5
	"	9.0/13.3	34.0/51.0	90.78
	"	11.0/16.5 ^{2/}	32.0/48.0	69.42

NOTE: ^{1/} For comparison; not an embodiment of invention.

^{2/} Cured casting showed opacity; believed due to phasing-out of some of VRP.

An optimum VRP content for impact strength improvement will be noted. It will also be apparent, by extrapolation, that even as little as 1 wt. percent

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of the VRP would effect a substantial improvement in impact strength.

G. Pilot plant scale preparation of dicyclopentadiene-modified, unsaturated polyesteramide.

5 A dicyclopentadiene-modified, unsaturated polyesteramide resin was prepared in a 10-gallon, 316 stainless steel reactor. The reactor was equipped with mechanical stirring, flowmeter controlled inlet lines and associated valving for nitrogen, water, dicyclopenta-
10 diene, propylene glycol-piperazine solution, and styrene. The respective liquid reactants were metered into the reactor from individual stainless steel bombs under positive nitrogen pressure with calibrated pumps. A digital scale was used to monitor the weight loss from
15 each bomb during pumping. Heating and cooling was provided to the reactor jacket via a recirculating pump for the heat transfer fluid. Trombone cooling coils with a water curtain system provided for rapid cooling when activated. The reactor overhead section was
20 fitted with a manway (for charging solid maleic anhydride briquettes or hydroquinone) and a steam-jacketed condenser. The overhead section of the steam condenser was chilled via a refrigeration unit. Liquid from the condenser accumulated in a receiver fitted with a drain valve.
25 Product was recovered from the reactor through a gate valve into a 10-micron filter assembly which led to a valved drumming outlet.

The following reaction stoichiometry was used:

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Maleic anhydride	7940 grams
Water	1600 grams
Dicyclopentadiene (96%)	9630 grams
11.17% wt. piperazine in 5 propylene glycol solution	3750 grams
Hydroquinone	2.75 grams
Styrene	12,803 grams.

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The following reaction sequence was used:

	<u>Reaction Step</u>	<u>Cumulative Reaction Time</u>
	Maleic anhydride charged	0 minutes
5	1/2 Water charged to stirred 90°C maleic anhydride solution	28 minutes
	Dicyclopentadiene addition started	30 minutes
	1/2 Water charged	45 minutes
	Dicyclopentadiene addition completed	58 minutes
10	Hydrolysis reaction completed [% dicyclopentadiene/acid number] unreacted	2.0 hours [1.0%/255]
	Piperazine-propylene glycol solution added and temperature controller set at 160°C	2.0 hours 20 minutes
15	Reaction at 160°C completed [acid number]	4.0 hours 15 minutes [129]
	Temperature set at 205°C	4.0 hours 25 minutes
	Nitrogen sparge set at 1 GPH	12.0 hours 15 minutes
20	Reaction at 205°C completed and cooling started [acid number]	17.0 hours 15 minutes [19.7]
	Hydroquinone added	17.0 hours 43 minutes
	Styrene added	18.0 hours 50 minutes
	Styrenated resin drummed	20.0 hours 15 minutes

Example 4 - Effect of VRP-A on properties of Alkyd G

Example 4 - Effect of the

25 A portion of the styrenated alkyd G was formulated with VRP-A in the relative amounts of 92.5 percent and 7.5 percent, by weight, respectively, to provide an uncured composition of the present invention. A second portion of styrenated alkyd G was used as

30 such, for comparison.

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(A) Clear, unfilled castings of the VRP-modified and the unmodified alkyd resin (styrenated alkyd) were prepared and tested as in Example 1. The results are given in Table 4.

TABLE 4

	Resin with VRP-A (7.5%)	Resin without VRP
Brookfield Viscosity (cp)	243	132
SPI Gel Test		
10 Gel time (min)	6.6	3.0
Cure time (min)	10.2	5.5
Maximum exotherm (°C)	187	216
Average Barcol Hardness	40	46
Heat Distortion Temperature (°C)	102	113
15 Tensile Strength (kPa)	52,400	37,900
Elongation (%)	2.2	1.2
Flexural Strength (kPa)	83,400	90,300
Flexural Modulus $\times 10^{-5}$ (kPa)	33.1	40.68

Again, improvements in tensile strength and percent elongation resulted from inclusion of the VRP.

It is to be noted that the to-be-expected decreases in flexural moduli, Barcol hardnesses, heat distortion temperatures (and reactivity) experienced - as indicated in the several foregoing tables - are not such that said properties of the flexibilized resins are outside of the acceptable ranges for most, if not all, end uses.

(B) Ductility comparisons were carried out, according to the Biaxial Yield Test methods of P. B. Bowden and J. A. Jukes, Journal of Materials Science, 3, 183 (1968) and 7, 52 (1972), on test specimens prepared from 0.16 cm thick, clear, unfilled castings of the VRP-modified and unmodified alkyd and having the following dimensions: 16.51 cm long x 1.59 cm wide at tab ends and 1.02 cm wide at center.

The specimen cross-sectional area was 0.16 cm², the tensile load was increased in 564 psi increments and the creep rate (yield) was about 0.0051 cm/minute. Tension vs. compression yield point values (psi) were plotted and the plot extrapolated to give tensile and compressive yield strength values. Ductility was calculated as 1 minus the ratio of compression at break to compressive yield strength. (Ductility may alternatively be calculated as the ratio of tension at break to tensile yield strength.) The results are given in Table 5.

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TABLE 5

	<u>Resin with VRP-A (7.5%)</u>	<u>Resin without VRP</u>
Ductility	0.409	0.060
5 Tension at Break (kPa)	30,469	6,336
Compression at Break (kPa)	63,682	127,661
Tensile Yield Strength (kPa)	74,466	(1)
Compressive Yield Strength (kPa)	107,024	135,811
Breakpoint	pp ⁽²⁾	pp ⁽²⁾
10 Last Weight Increment Added (Kg.)	0.91	0

(1) Cannot be extrapolated accurately with datapoints collected.

(2) Prior pinchpoint.

15 A very substantial and significant improvement in ductility upon incorporation of the VRP is evident. A correspondingly "tougher" resin results.

H. Preparation of a VRP having an ideal structure incorporating two polyglycol units and three diisocyanate units. (Acrylate/diisocyanate/glycol mole ratio = 1/1.5/1)

20 A mixture of 2473 grams (1.2365 gram moles) of polypropylene glycol (P-2000) and 1 gram of stannous octoate was added with stirring to a mixture of 330 grams (1.897 g moles) of toluene diisocyanate (80/20 mixture of 2,4-and 2,6-isomers) and 0.465 grams of
25 stannous octoate and stirring was continued until the

reaction was complete (-OH IR absorption gone).

162.5 Grams (1.25 g moles) of 2-hydroxyethyl acrylate (and a small amount of methylethylhydroquinone vinyl stabilizer) was then stirred into the reaction mixture and allowed to react until the -OH IR absorption was minimized and the urethane carbonyl absorption maximized. A small amount of toluene diisocyanate was added to react out the last of the -OH and then the residual -NCO was reacted out by adding about 0.5-1.0 grams of isopropanol. The resulting product, a very viscous, clear light yellow-colored liquid, was then diluted with styrene to an 80 wt. percent VRP content solution, designated herein as "VRP-H".

15 (Comparative) Example 5 - Effects of VRP-H on properties of dicyclopentadiene-modified, unsaturated polyesteramide Alkyd F).

This example demonstrates the relatively poor toughening which results when substantial phasing out occurs during curing. 199.5 grams of alkyd F was mixed with 32.81 grams of the VRP/styrene solution (VRP-H) and with 122.69 grams of styrene to provide a 57 percent alkyd/7.5 percent VRP and 35.5 wt. percent styrene formulation. A 57 percent alkyd/43 percent styrene formulation (no VRP) was made up from the same alkyd (F) for comparison. The physical and mechanical properties of the two formulations were determined by the methods described in the in the previous examples herein. The results are given in Table 6.

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TABLE 6

	Property	Formulation	
		With VRP-H	Without VRP
5	Brookfield Viscosity (cp)	919	184.
	SPI Gel Test		
	Gel Time (min)	7.6	2.7
	Cure Time (min)	10.1	7.9
	Maximum Exotherm (°C)	202	221
10	Average Barcol Hardness	35	41
	Heat Distortion Temperature (°C)	110.5	115.5
	Tensile Strength (kPa)	37,200	35,200
	Elongation (%)	2.7	1.1
	Flexural Strength (kPa)	71,000	100,000
15	Flexural Modulus x 10 ⁻⁵ (kPa)	26.2	40.68
	Unnotched Izod Impact (Joules/met.)	126	42.7

20 A small increase in tensile strength and substantial increases in elongation and impact strength may be noted. Virtually no change in heat distortion temperature occurred.

25 It was observed that the cured formulation samples containing VRP-H were opaque, indicating that at least some of the VRP had phase separated. The relatively low improvement in tensile strength experienced is believed attributable to this pronounced phasing behavior. (Effective toughening requires increases in both tensile strength and elongation.)

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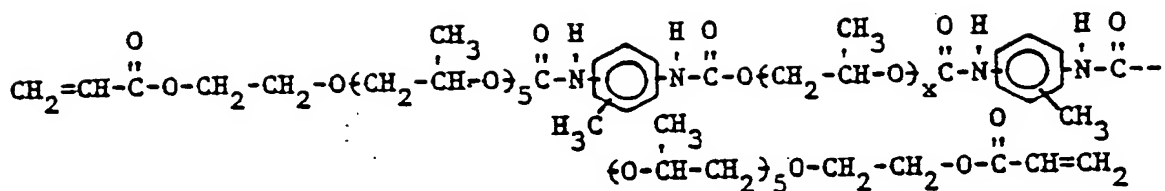
I. Preparation of a VRP comprising alkylene oxide-extended hydroxy-functional acrylate end groups.

Polypropylene glycol (0.06375 mole, 127.5 grams) with an average molecular weight of 2000 and containing dissolved stannous octoate (0.1105 gram) and an organo tin salt commercially available from Witco Chemical Co. as Fomrez UL-28 (0.1105 gram) was added over a one-minute period to a glass reactor containing stirred toluene diisocyanate (0.1275 mole, 22.21 grams) under a nitrogen atmosphere. The toluene diisocyanate used was an 80 to 20 weight percent mixture of the 2,4- and 2,6-isomers, respectively. A maximum exotherm to 51°C occurred three minutes later; then the reaction temperature was increased to 60°C. After 44 minutes at the 60°C reaction temperature, infrared spectrophotometric analysis of a film sample of the transparent reaction product demonstrated that the reaction of the isocyanate with the aliphatic hydroxyl group was complete (disappearance of hydroxyl group, appearance of urethane carbonyl group). 51.19 Grams (0.1275 moles) of the mono(2-hydroxyethylacrylate)ether of pentapropylene glycol-1,2 was then added. The reaction temperature was maintained at 60°C and after 78 minutes, infrared spectrophotometric analysis of a film sample of the transparent reaction product demonstrated that the reaction of the remaining isocyanate groups with the aliphatic hydroxyl group was complete. Hydroquinone (100 ppm) was added to the reactor and the resulting VRP (designated herein as VRP-I) was recovered.

(Acrylate/diisocyanate/glycol mole ratio = 2/2/1.)

The oligomer (VRP-I) had the statistical structure (VI):

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5

$$x = \sim 34.$$

and, by reason of the at least ten more propylene oxide units it contains, has a substantially higher molecular weight than VRP-A.

Example 6 - Effect of VRP-I on properties of alkyd F.

10

Borderline example of the invention.

15

199.5 Grams of alkyd F was combined with 129.25 grams of styrene and 26.25 grams of VRP-I to give a 57.0/35.5/7.5 percent formulation (an uncured composition of the present invention). A portion of the 57 percent alkyd/43 percent styrene formulation described in Example 5 was used for comparison. The properties of the two formulations given in Table 7 were determined by the methods described earlier herein.

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TABLE 7

	Alkyd F/Styrene Formulation	
	<u>With VRP-I</u>	<u>Without VRP</u>
5 Brookfield Viscosity (cp)	647	184
SPI Gel Test		
Gel Time (min)	4.4	2.7
Cure Time (min)	7.3	4.9
10 Maximum Exotherm (°C)	201	221
Average Bacrol Hardness	40	41
Heat Distortion Temperature (°C)	114	115
Tensile Strength (kPa)	38,600	35,200
Elongation (%)	1.6	1.1
15 Flexural Strength (kPa)	76,500	100,000
Flexural Modulus x 10 ⁻⁵ (kPa)	31	40.68
Unnotched Izod Impact (Joules/met.)	90.8	42.7

20 The increase in elongation was less than that obtained with VRP-H in Example 5.

25 However, it is interesting to note the greater increase in tensile strength and quite small decreases in HDT and Barcol hardness consequent upon inclusion of the VRP. In this case, only a very slight haziness was observed in the (otherwise clear) cured VRP-comprising specimens. This may be attributable not only to the molecular weight increase resulting from the extra propylene oxide units (vis-a-vis VRP-A; same stoichiometry) but also to the effect of inserting the

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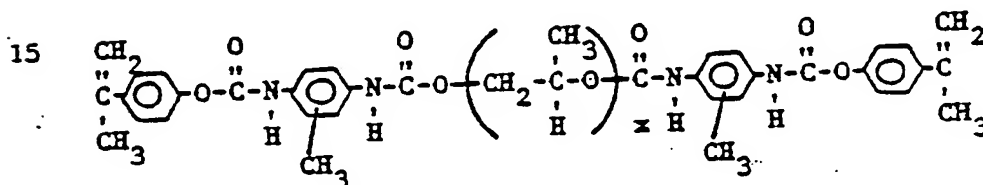
extra units between the acrylate and carbamate groups in the oligomer. (Use of a lower proportion of VRP-I than 7.5 percent might result in elimination of the haziness in the cured composition.)

- 5 J. Preparation of a vinyl-terminated urethane oligomer ("VRP-J") comprising isopropenyl phenol-derived end groups. (Vinyllic phenol/diisocyanate/glycol mole ratio 2/2/1.)

10 Toluene diisocyanate (0.255 mole, 44.41 grams), p-isopropenyl phenol (0.255 mole, 34.21 grams), and phenothiazine (0.055 weight percent, 0.167 grams) were added to a glass reactor and maintained under a nitrogen atmosphere with stirring. The toluene diisocyanate was an 80 to 20 weight percent mixture of the
15 2,4- and 2,6-isomers, respectively. The p-isopropenyl phenol contained less than 1.6 weight percent dimer and only a trace of residual phenol. The reactants were heated to 45°C. A catalyst package consisting of an organo tin salt commercially available from Witco
20 Chemical Co. as FOMREZ UL-28 (0.152 grams) and a tertiary amine commercially available from Abbot Labs as Polycat DBU (0.152 grams) was added to the stirred slurry and air cooling of the reactor exterior was started. A maximum exotherm to 82°C occurred four minutes later.
25 Cooling reduced the temperature of the reactor contents to 60°C and this temperature was maintained for 56 minutes. At this time, infrared spectrophotometric analysis of a film sample of the transparent, pale yellow-colored reaction product demonstrated that the
30 reaction of the isocyanate with the phenolic hydroxyl was essentially complete (disappearance of hydroxyl group, appearance of carbonyl group). Polypropylene

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glycol (0.1275 mole, 225.0 grams) with an average molecular weight of 2000 was added to the reactor, followed by the addition of more catalyst, Witco FOMREZ UL-28 (0.076 grams) and POLYCAT DBU (0.152 grams). A maximum exotherm of 68°C occurred eleven minutes later. Cooling reduced the reaction temperature to 65°C and this reaction temperature was maintained for 3.8 hours. At this time, infrared spectrophotometric analysis of a film sample of the white-colored, viscous, liquid reaction product demonstrated that the reaction of the remaining isocyanate groups with the aliphatic hydroxyl groups was complete. The reactor contents were cooled and a vinyl-reactive "oligomer" (VRP-J) of the following statistical formula (VII) was recovered:



where $x = \sim 34$.

20 Example 7 - Effect of VRP-J on properties of a dicyclopentadiene-modified, unsaturated polyester (essentially identical to alkyd E).

identical to alkyd E).

A curable composition of the present invention was prepared by blending together 199.5 grams of the modified polyester alkyd, 24.5 grams of VRP-J and 126.0 grams of styrene. Cured test specimens were prepared from the latter solution (57 percent alkyl/7 percent VRP/36 percent styrene) and from a 57 percent alkyl/43 percent styrene (no VRP) blend and tested as described in the previous examples herein. The results are given in Table 8, following.

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TABLE 8

		Alkyd/Styrene Formulation	
		With VRP-J	Without VRP
5	Brookfield Viscosity (cp)	158	42
	SPI Gel Test		
	Gel Time, min.	5.5	3.0
	Cure Time, min.	11	5.5
10	Maximum Exotherm (°C)	176	226
	Average Barcol Hardness	35	35
	Heat Distortion Temperature, °C	87.8	114
	Tensile Strength, (kPa)	46,200	31,700
15	Elongation (%)	2.1	0.9
	Flexural Strength, (kPa)	100,600	66,900
	Flexural Modulus, $\times 10^{-5}$ (kPa)	29.6	42
	Unnotched Izod Impact Strength Joules/met.	85.44	53.4
20	Biaxial Yield Test:		
	Ductility	0.67	0.07
	Tension at break, kPa	46,700	5992
	Compression at break, kPa	35,054	131,080
	Tensile Yield Strength, kPa	69,639	*
25	Compressive Yield Strength, kPa	106,231	140,534

* Cannot be extrapolated accurately from data-points collected.

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Impressive improvements in tensile strength, elongation, flexural strength, impact strength and ductility will be seen to have resulted from inclusion of the VRP.

5 Example 8 - Effect of VRP-J on properties of a dicyclo-
pentadiene-modified, unsaturated polyesteramide essentially
identical to alkyd F.

10 A 199.5 gram portion of the polyesteramide
alkyd was mixed with 126.0 grams of styrene and 24.5
grams of VRP-J to provide an uncured composition of the
invention comprising 57 percent by wt. of the resin, 36
percent styrene and 7 percent of the VRP. An otherwise
identical formulation, sans VRP, and containing 57
percent alkyd and 43 percent styrene was made up for
15 comparison. The physical and mechanical properties of
the two formulations were determined as described
earlier herein and are given in Table 9.

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TABLE 9

	Alkyd/Styrene Formulation	
	With VRP-J	Without VRP
5 Brookfield Viscosity (cp)	669	184
SPI Gel Test		
Gel Time, min.	5.4	2.7
Cure Time, min.	9.6	4.9
10 Maximum Exotherm (°C)	179	221
Average Barcol Hardness	36	46
Heat Distortion Temperature, °C	100	115
Tensile Strength, (kPa)	41,400	35,200
15 Elongation (%)	1.9	1.1
Flexural Strength, (kPa)	66,900	100,000
Flexural Modulus, $\times 10^{-5}$ (kPa)	28.3	40.7
Unnotched Izod Impact Strength Joules/met.	90.8	53.4

20 It will again be seen that substantial improvements in tensile strength, elongation and impact strength resulted from inclusion of the VRP. The other properties were not significantly degraded.

25 The parts of VRP per hundred parts of resin, or phr values, corresponding to the wt. percent compositions given in the foregoing Examples are given below in Table 10.

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TABLE 10

phr Contents of VRP and Styrene in
Exemplary Compositions of the Present Invention

5	Example No.	Composition					Notes
		Alkyd Wt. %	Styrene Wt. %	phr	VRP- Wt. %	phr	
	1	C 57.0	35.5	62.28	A 7.5	13.16	
10	2	E 57.0	34.0	59.65	A 9.0	15.79	
	3	F 57.0	41.0	71.93	A 2.0	3.51	
		"	39.0	68.42	4.0	7.02	(Best of Series)
		"	36.0	63.16	7.0	12.28	
15		"	34.0	59.65	9.0	15.79	
		"	32.0	56.14	11.0	19.30	
	4	G (Includes Styrene) 92.5			A 7.5	8.11	
20	5	F 57.0	35.5	62.28	H 7.5	13.16	
	6	F 57.0	35.5	62.28	I 7.5	13.16	
	7	like E 57.0	36.0	63.16	J 7.0	12.28	
25	8	like F 57.0	36.0	63.16	J 7.0	12.28	

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An additional class of polycycloalkenyl-terminated unsaturated polyesters or polyesteramides suitable for use in the present invention is taught in a co-pending application of the present inventor,
5 Serial No. 545,024, filed October 24, 1983, the disclosure of which is hereby incorporated herein by reference. A resin oil is used to prepare this class of polyester or polyesteramide alkyds (or resins).

Resin oils are complex mixtures which contain
10 three distinct types of components:

esterifiable hydrocarbon reactives including
dicyclopentadiene, methyl dicyclopentadiene,
indene, methyl indene, cyclopentadiene codimers,
diolefin dimers and the like; ethylenically
15 unsaturated aromatic hydrocarbon reactives including
styrene, vinyl toluene, allyl benzene and the
like; and non-reactive hydrocarbons including
aromatic, alkylaromatic, polyalkylaromatic hydro-
carbons and the like.

20 The resin oils which may be used herein are
generally obtained as distillation cuts from hydrocarbon
processing. The composition of the resin oil can vary
within wide limits depending on the hydrocarbon feedstock
being processed, the type of process, the distillation
25 conditions and many other known variables. The amount
of the esterifiable hydrocarbon reactives component
operable in these reactions can vary from about 25
percent by weight (pbw) to about 95+ pbw. The amount
of the ethylenically unsaturated aromatic hydrocarbon
30 reactives component can vary from about 5 pbw to about
50 pbw. The remainder is the non-reactive hydrocarbon
component.

The new class of unsaturated polyesters or polyesteramides may be made by the previously described methods. The prehydrolysis method is most preferred wherein a 50 to 100 mole percent excess of water based on moles of maleic anhydride used is employed. In these methods, the esterifiable hydrocarbon reactives components, such as dicyclopentadiene and the like are incorporated into the unsaturated polyester or polyesteramide in the same manner as previously described herein, for example for dicyclopentadiene. This reaction occurs in the presence of the ethylenically unsaturated aromatic hydrocarbon reactives and non-reactive hydrocarbon components of said resin oil. In the most preferred process of the present invention, the ethylenically unsaturated aromatic hydrocarbon reactives undergo polymerization reactions concurrently with the reaction of the esterifiable hydrocarbon reactives. However, it is operable to partially or totally polymerize the ethylenically unsaturated aromatic hydrocarbon reactives component prior to reaction of the esterifiable hydrocarbon reactives.

When a resin oil is used, a substantial amount of the non-reactive hydrocarbon component is removed along with the water from the reaction. Lesser amounts of non-reactive hydrocarbon component remaining in the unsaturated polyester are useful for plasticization and flexibilization of the unsaturated polyester, thus resulting in improved mechanical properties.

The resulting product is a hydrocarbon-modified unsaturated polyester or polyesteramide alkyd containing the polymerization products of the ethylenically unsaturated aromatic hydrocarbon reactives component

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and, optionally, minor amounts of the non-reactive hydrocarbon component. The alkyd is blended with an ethylenically unsaturated monomer as herein-before described.

5 K. Preparation of Resin Oil Modified Unsaturated Polyesteramide Resin

A resin oil modified unsaturated polyesteramide resin was prepared in a 378 Lit. 316 stainless steel reactor. The reactor was equipped with mechanical stirring, flowmeter controlled inlet lines and associated valving for nitrogen, water, resin oil, ethylene glycol-piperazine solution and styrene. The resin oil used contained 63.06 percent by weight (pbw) esterifiable hydrocarbon reactives consisting of isoprene-
10 -cyclopentadiene codimer (1.65 pbw), indene (4.03 pbw), methyl cyclopentadiene-cyclopentadiene codimer (6.17 pbw), butadiene-cyclopentadiene codimer (5.32 pbw) and dicyclopentadiene (45.89 pbw); ethylenically unsaturated aromatic hydrocarbon reactives consisting of styrene
15 and vinyl toluenes (15.96 pbw); cyclopentadiene (1.56 pbw); and non-reactive hydrocarbons (19.42 pbw). The respective liquid reactants were metered into the reactor from individual drums using calibrated drum pumps. A scale was used to monitor the weight loss
20 from each drum during pumping. Heating and cooling were provided to the reactor jacket via a recirculating pump for the heat transfer fluid. Heat was provided to the heat transfer fluid reservoir via a pair of thermostated in-line electric heaters. Finned cooling
25 coils with a water curtain provided for rapid cooling when activated. The reactor overhead section was fitted with a manway for charging solid maleic anhydride
30

briquettes or hydroquinone and a steam-jacketed condensor. A chilled water condensor and knock-out pot fitted with a drain valve were used to recover condensate from the steam-jacketed condensor. Product was recovered from the reactor through a ram valve into a 10 micron filter assembly and to a valved drumming outlet.

The following reaction stoichiometry and sequence were used:

	<u>Reaction Step</u>	<u>Cumulative Reaction Time</u>
10	Water addition (14.1 Kg at 0.12 lit/min) started into 100°C stirred solution of maleic anhydride (76.7 Kg) under 0.375 scfh nitrogen	0 minutes
15	First 14.1 Kg of water in, start bulk addition of second 14.1 Kg of water	1 hour, 45 minutes
20	All water added, reaction temperature between 90-110°C, start recycling water and hydrocarbon distillate back into reactor	1 hour, 50 minutes
	Start resin oil addition (145.3 Kg at 2.5 lit/min)	2 hours
25	Resin oil addition completed temperature controller set at 135°C	2 hours, 55 minutes
30	Hydrolysis reaction completed, recycle of water and hydrocarbon distillate into reactor stopped (acid number = 218)	4 hours, 55 minutes

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	<u>Reaction Step</u>	<u>Cumulative Reaction Time</u>
5	Piperazine-ethylene glycol solution (30.3 Kg) added, temperature controller set at 160°C, nitrogen sparge set to 7.5 scfh, 2,5-di-tert-butylhydroquinone (12.6 grams) added as process inhibitor	5 hours, 50 minutes
10	Reaction at 160°C completed, temperature controller set at 205°C (acid number = 120)	7 hours, 50 minutes
	205°C reached	10 hours
	Nitrogen sparge set at 2.75 scfh	11 hours, 40 minutes
15	Reaction at 205°C completed, cooling started, turn nitrogen sparge down to 0.375 scfh	15 hours, 30 minutes
20	Hydroquinone (58.9 grams) added at 150°C (acid number = 27)	16 hours, 40 minutes
	2% O ₂ in N ₂ started at 125°C	17 hours, 15 minutes
25	Styrene (169.1 Kg) added at 110°C	18 hours
	Styrenated resin drummed ¹	19 hours, 30 minutes

¹Contained 43 percent by styrene

L. Preparation of VRP-L (Acrylate/diisocyanate/-polyol Ratio = 3/3/1).

- 30 Toluene diisocyanate (208.99 grams; 1.2 moles) and phenothiazine (0.31 gram) were added to a reactor and maintained at 21°C under a nitrogen atmosphere with stirring. A mixture of a polypropylene (ethylene) glycol adduct of glycerin prepared by reaction

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of a 92.0 percent propylene oxide, 8.0 percent ethylene oxide mixture with glycerin to a 3000 average molecular weight (1200 grams; 0.4 moles); stannous octoate (0.85 grams) and an organotin salt (Dabco 33LV) (0.85 gram) were added over a ten-minute period and so as to maintain a reaction temperature of 56°C. After completion of the addition, the reaction temperature was increased to 65°C and held for 75 minutes. At the end of this post reaction time, 2-hydroxyethyl acrylate (139.27 grams; 1.20 moles) was added over a one-minute period. An exotherm to 73°C occurred and the reactor was then heated to 76°C and held at this temperature for 90 minutes. The product was inhibited with 0.08 gram of hydroquinone and then recovered in essentially quantitative yield.

Example 9 - Effect of VRP-L on Resin K.

Clear, unfilled 1/8 inch castings were prepared and evaluated (as previously described) using the specified blends of the Resin Oil-modified unsaturated polyesteramide resin and VRP-L. The following results were obtained:

Percent by Weight VRP	None ⁽¹⁾	4.9	10.0	15.2
Tensile Strength (kPa)	49,782	49,437	39,991	19,237
Elongation (%)	1.70	2.20	4.40	12.40
Flexural Strength (kPa)	71,639	74,052	71,087	32,958
Flexural Modulus (kPa)	4,164,580	4,370,740	2,158,135	1,029,423
Visual Appearance	Monophasic	Monophasic	Monophasic	Monophasic

(1) Not an embodiment of the invention

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The difference in tensile strengths for the compositions containing 0 and 4.9 weight percents of the VRP-L is within the range of experimental error and is not considered significant. Inasmuch as elongation was substantially increased, however, toughening was accomplished at the 4.9 percent level.

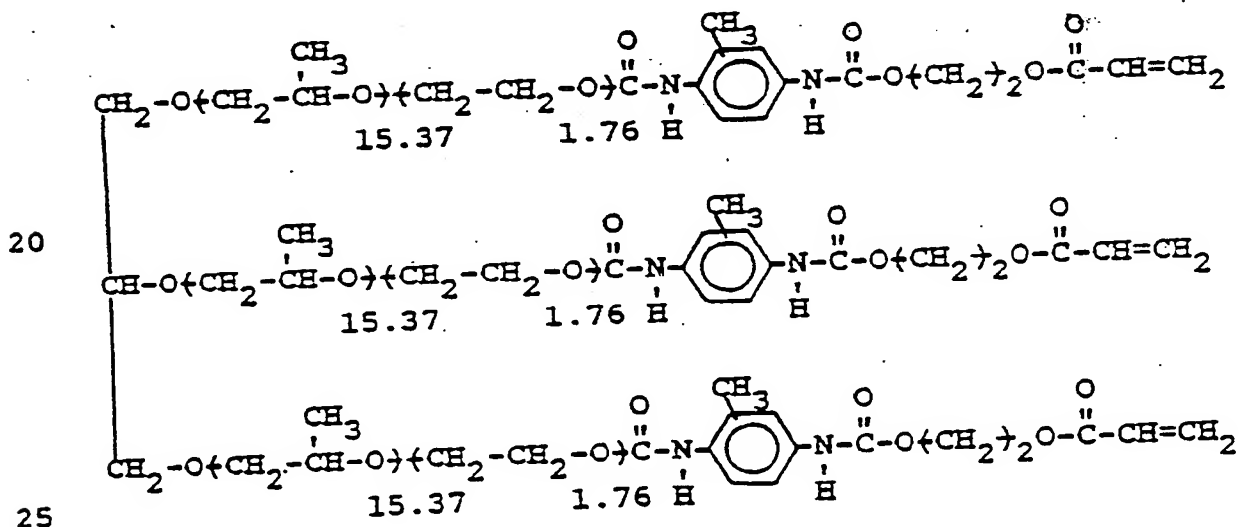
Example 10 - Combination of an internally flexibilized alkyd and a VRP in which the polyglycol component is a hydroxyalkylated glycerine.

10 A. Preparation of Vinyl Terminated Urethane Oligomer from a Hydroxyalkylated Glycerin, Toluene Diisocyanate and 2-Hydroxyethyl Acrylate

15 Toluene diisocyanate (1.20 moles, 208.99 grams) and phenothiazine (0.02 percent by weight 0.31 gram) were added to a reactor and maintained with stirring at 21°C under a nitrogen atmosphere. The toluene diisocyanate used was an 80 to 20 weight percent mixture of the 2,4- and 2,6-isomers, respectively. Polypropylene (ethylene) glycol adduct of glycerin prepared by reaction of a 92.0 percent propylene oxide then 8.0 percent ethylene oxide with glycerin to a 3000 average molecular weight (1.20 moles of hydroxyl groups, 1200.0 grams) was mixed with stannous octoate (0.055 percent by weight, 0.85 gram) and a tertiary alkyl amine catalyst (Dabco 33LV) (0.055 percent by weight, 0.85 gram) and this mixture was added to the reactor over a 10 minute (800 s) period. A maximum exotherm of 56°C was obtained at the end of the hydroxyalkylated glycerin and catalyst addition, then heating commenced and a reaction temperature of 65°C was achieved six (360 s) minutes later. The reaction was allowed to

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progress for 75 minutes (4500 s) at 65°C after which
time infrared spectrophotometric analysis of a film
sample of the reaction product demonstrated essentially
complete reaction (disappearance of hydroxyl group
5 absorbance). At this time, 2-hydroxyethyl acrylate
(1.20 moles, 139.27 grams) was added to the reactor
over a one-minute (60 s) period. A maximum exotherm of
73°C occurred, then the reactor was heated to 76°C and
held at this temperature for 90 minutes (5400 s) after
10 which time infrared spectrophotometric analysis of a
film sample of the reaction product demonstrated essen-
tially complete reaction (disappearance of isocyanate
group absorbance). Hydroquinone (0.08 gram) was added
as an inhibitor and the product was recovered as a
15 transparent, viscous liquid of the following statistical
structure, corresponding to a molecular weight of 3830:



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B. Preparation of Dicyclopentadiene Modified Unsaturated Polyesteramide with Flexibilizing Glycol Ether Component

A dicyclopentadiene modified unsaturated polyesteramide was prepared in a 100 gallon, 316 stainless steel reactor. The reactor was equipped with mechanical stirring, flowmeter controlled inlet lines and associated valving for nitrogen, dicyclopentadiene concentrate, propylene glycol-piperazine-polypropoxylate of glycerin with propylene oxide (1 to 9 mole ratio) solution, and styrene. The dicyclopentadiene concentrate contained 99.23 percent by weight esterifiable hydrocarbon reactives including 81.4 percent by weight dicyclopentadiene, 11.86 pbw isoprene-cyclopentadiene codimer, 0.16 pbw tricyclopentadiene and 0.59 pbw methyl cyclopentadiene-cyclopentadiene codimer.

The respective liquid reactants were metered into the reactor from individual drums using calibrated drum pumps. A scale was used to monitor the weight loss from each drum during pumping. Heating and cooling were provided to the reactor jacket via a recirculating pump for the heat transfer fluid. Heat was provided to the heat transfer fluid reservoir via a pair of thermostatted in-line electric heaters. Finned cooling coils with a water curtain provided for rapid cooling when activated. The reactor overhead section was fitted with a manway for charging solid maleic anhydride briquettes or hydroquinone and a steam-jacketed condenser. A chilled water condenser and knock-out pot fitted with a drain valve were used to recover condensate from the steam-jacketed condenser. Product was recovered from the reactor through a ram valve into a 10 micron filter assembly and to a valved drumming outlet.

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The following reaction stoichiometry was used:

	maleic anhydride	65.5 Kg.
	water	13.2 Kg.
5	dicyclopentadiene concentrate	79.7 Kg.
	72.64% wt. polypropoxylate of glycerin and 4.34% wt. piperazine in propylene glycol solution	79.5 Kg.
10	hydroquinone - Addition 1	5.6 grams
	Addition 2	58.9 grams
	styrene	169.1 Kg.

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The following reaction sequence was used:

	<u>Reaction Step</u>	<u>Cumulative Reaction Time</u>
	Water addition started into 70°C stirred solution of maleic anhydride and hydroquinone (addition 1) under 0.38 scfh nitrogen	0 minutes
5		
	Dicyclopentadiene concentrate addition started	2 minutes
	Water and dicyclopentadiene concentrate additions completed	2 minutes
10		
	Hydrolysis reaction completed (acid number)	4 hours 45 minutes (259)
	Piperazine-propylene glycol-glycerin polypropoxylate solution added, temperature controller set at 160°C, nitrogen sparge set to 2 scfh	5 hours
15		
	Reaction at 160°C completed and temperature set at 205°C	7 hours 45 minutes
	Nitrogen sparge set at 2.8 scfh	15 hours 45 minutes
20		
	Reaction at 205°C completed and cooling started (acid number)	19 hours 45 minutes (27)
	Hydroquinone (addition 2), 2% O ₂ in N ₂ started	20 hours 40 minutes
	Styrene added at 110°C	22 hours 40 minutes
25	Styrenated resin drummed ¹	25 hours 10 minutes

¹ Contained 43 percent by weight styrene.

C. Preparation and Curing of Vinyl Terminated Urethane Oligomer and Dicyclopentadiene Modified Unsaturated Polyesteramide Resin Formulations

30 Portions of the vinyl terminated urethane oligomer from A above and portions of the dicyclopentadiene modified unsaturated polyesteramide resin from B

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above were blended with additional styrene to provide the following formulations:

<u>Component</u>	<u>Formulations (wt. percent/PHR)</u>		
	<u>A</u>	<u>B</u>	<u>C</u>
	<u>Wt. %/PHR</u>	<u>Wt. %/PHR</u>	<u>Wt. %/PHR</u>
5 Vinyl terminated urethane oligomer	14.8/40.8	17.2/49.6	19.5/58.5
Dicyclopentadiene modified unsaturated polyesteramide alkyd (styrene-free basis)	36.3/100	34.7/100	33.3/100
10 Styrene (from resin plus added)	48.9/135	48.1/139	47.2/142

Clear unfilled 1/8 inch castings were prepared using a cure system consisting of 2 percent by wt. methyl ethyl ketone peroxide, 0.6 percent by wt. cobalt naphthenate (6 percent) and 0.3 percent by wt. dimethyl-aniline at room temperature (25°C). The castings were post-cured at 100°C for 2.0 hours, then used to prepare test pieces for evaluation of mechanical properties. The results were as follows:

	<u>FORMULATION</u>		
	<u>A</u>	<u>B</u>	<u>C</u>
20 Brookfield Viscosity (cp)	95	102	105
Elongation (%)	35.8	42.5	43.6
Tensile Strength (kPa)	35,751	29,290	26,153
25 Barcol Hardness	12	12	14
Visual Appearance	Monophasic	Monophasic	Monophasic

Using a cure system of 2.25 percent by wt. methyl ethyl ketone peroxide, 0.4 percent by wt. cobalt naphthenate (6 percent) and 0.2 percent by wt. dimethyl-

SECRET

aniline with formulation C provided the following results in the SPI gel test (84°C):

	gel time	0.9 min.
	cure time	2.75 min.
5	maximum exotherm	160.6°C

Using a cure system of 1.50 percent by wt. benzoyl peroxide and 0.5 percent by wt. dimethylaniline with formulation C provided the following results in the SPI gel test (84°C):

10	gel time	1.25 min.
	cure time	3.4 min.
	maximum exotherm	181.8°C

It will be seen that extraordinarily high percent elongation values resulted. The tensile strength decreased as the amount of the VRP was increased from 40.8 to 58.5 phr but was still more than adequate. Formulations (VRP/alkyd/styrene resins) of the type disclosed in this example have been found eminently suitable for inclusion in so-called polymer concretes to be used in bridge surface overlays.

SUBSTITUTE SHEET

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1. A curable, flexibilized polyester composition comprising, in admixture:

- 5 a. an unsaturated polyester- or polyesteramide-
 -alkyd having at least one polycycloalkenyl
 end group and optionally including a polyglycol-
 derived flexibilizing group,
- 10 b. a flexibilizing, polyglycol moiety-comprising
 urethane oligomer having (1) two or more
 terminal groups, at least one of which is
 vinyl-reactive, and (2) a weight average
 molecular chain extension, calculated as
 polystyrene, of less than 100Å,

and, optionally,

- 15 c. from about 25 to about 400 parts by weight of
 a non-resinous, vinyl monomer per hundred
 parts of said alkyd;

the parts by weight of said oligomer per hundred parts
of said alkyd being such that the oligomer will not
phase out when said composition is cured and being

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20 within the range of from about 1 to about 60 when the alkyd includes said flexibilizing group but being about 20 or less when the latter group is not included in the alkyd.

2. The composition of Claim 1 wherein said monomer is included and is styrene.

3. The composition of Claim 1 in which said alkyd has two of said polycycloalkenyl end groups.

4. The composition of Claim 1 in which at least two of the terminal groups in said oligomer are vinyl-reactive.

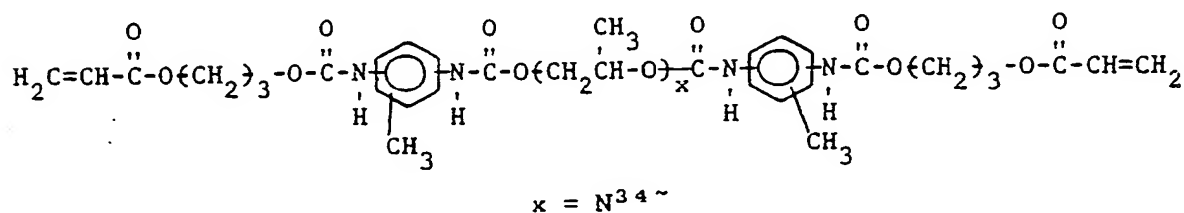
5. The composition of Claim 3 in which at least two of the terminal groups in said oligomer are vinyl-reactive.

6. The composition of Claim 5 in which each of said terminal groups are deriveable from a vinyl compound independently selected from the group consisting of hydroxyethyl or hydroxypropyl esters of acrylic or methacrylic acid, mono acrylates or methacrylates of polyethylene-, polypropylene or polybutylene glycols, isocyanatoethyl- or 2-isocyanatopropyl esters of acrylic or methacrylic acid, vinyl or isopropenyl isocyanate or an isopropenyl phenol.

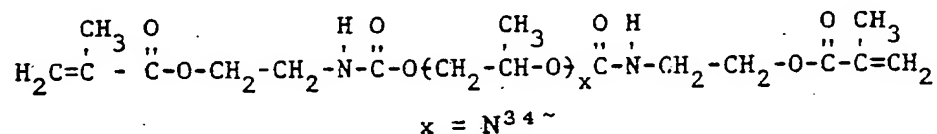
5

-70-

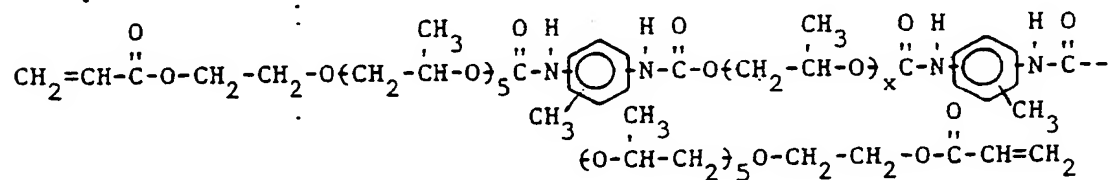
7. The composition of Claim 6 in which said oligomer is deriveable from 3-hydroxypropylacrylate and has the statistical formula



8. The composition of Claim 6 in which said oligomer is deriveable from 2-isocyanatoethyl methacrylate and has the statistical formula

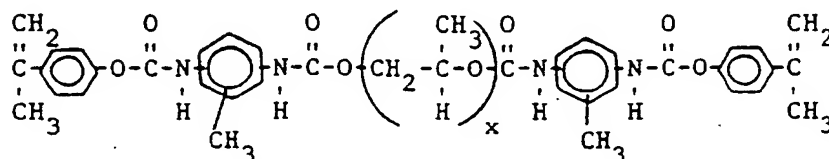


9. The composition of Claim 6 in which said oligomer is deriveable from the mono(2-hydroxyethyl-acrylate)ether of pentapropyleneglycol-1,2 and has the statistical formula



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10. The composition of Claim 6 in which said oligomer is deriveable from p-isopropenyl phenol and has the structural formula



where $x = N^{34} \sim$

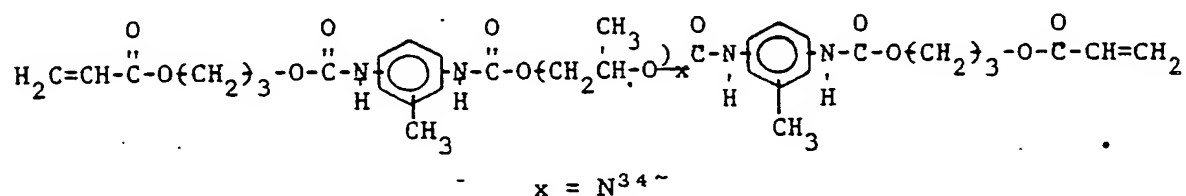
11. The composition of Claim 6 in which said monomer is included and is styrene.

12. The composition of Claim 11 in which said alkyd does not include said flexibilizing group and the styrene is present in the amount of from about 58 to about 68 phr.

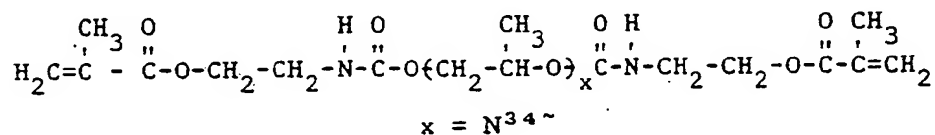
13. The composition of Claim 11 in which the alkyd includes said flexibilizing group and the styrene is present in the amount of from about 130 to about 150 phr.

-72-

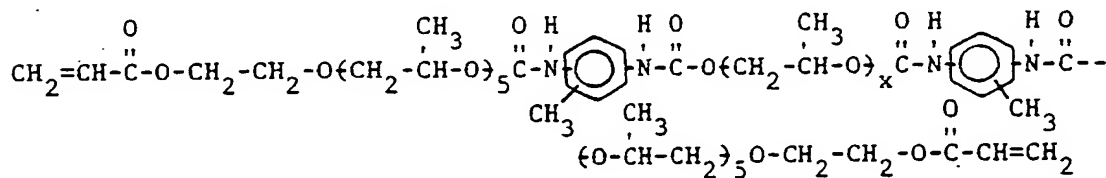
14. The composition of Claim 12 in which said oligomer is deriveable from 3-hydroxypropylacrylate and has the statistical formula



15. The composition of Claim 12 in which said oligomer is deriveable from 2-isocyanatoethylmethacrylate and has the statistical formula

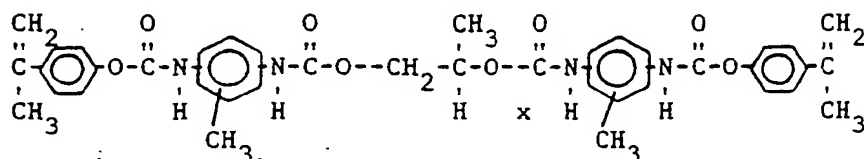


16. The composition of Claim 12 in which said oligomer is deriveable from the mono(2-hydroxyethylacrylate)ether of pentapropyleneglycol-1,2 and has the statistical formula



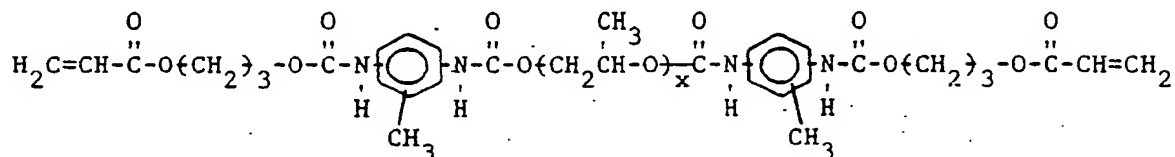
-73-

17: The composition of Claim 12 in which said oligomer is derivable from p-isopropenyl phenol and has the statistical formula

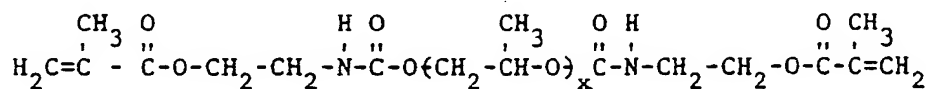


where $x = N^{3/4} \sim$

18. The composition of Claim 13 in which said oligomer is derivable from 3-hydroxypropylacrylate and has the statistical formula

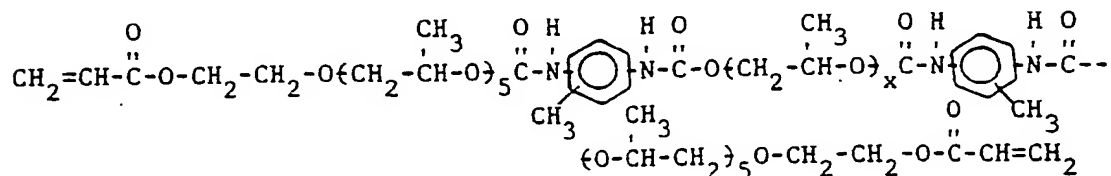

$$x = N^{3.4 \sim}$$

19. The composition of Claim 13 in which said oligomer is deriveable from 2-isocyanatoethyl-methacrylate and has the statistical formula


$$x = N^{3.4 \sim}$$

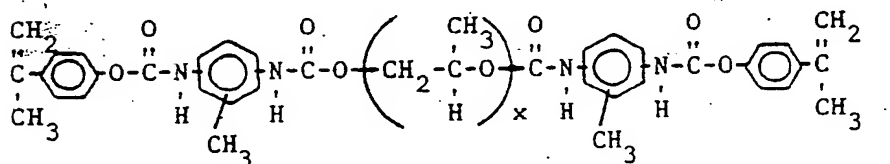
-74-

20. The composition of Claim 13 in which said oligomer is derivable from the mono(2-hydroxyethyl-acrylate)ether of pentapropyleneglycol-1,2 and has the statistical formula



wherein $x = N^{34} \sim$

21. The composition of Claim 13 in which said oligomer is derivable from p-isopropenyl phenol and has the statistical formula



where $x = N^{34} \sim$

22. The composition of Claim 12 in which the amount of said oligomer is from about 6 to about 16 phr.

23. The composition of Claim 22 in which the amount of said oligomer is from about 12 to about 16 phr.

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24. The composition of Claim 13 in which the amount of said oligomer is from about 41 to about 59 phr.

25. The composition of Claim 6 in which said alkyd is the reaction product of

(a) dicyclopentadiene or a concentrate thereof, maleic acid and, optionally, water,

5 or

(b) dicyclopentadiene or a concentrate thereof, water, and maleic anhydride or a mixture thereof with maleic acid,

with

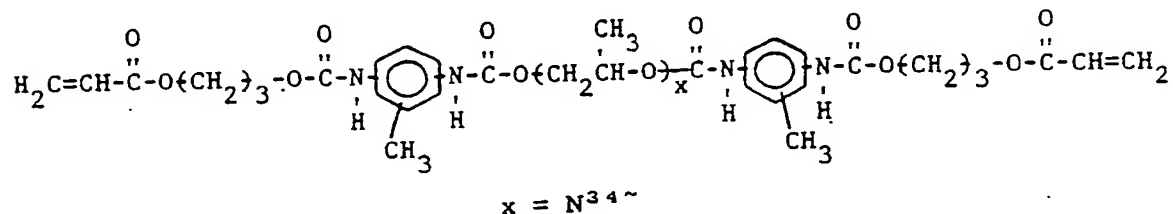
10. a polyol and, optionally, a diamine.

26. The composition of Claim 25 in which said monomer is included and is styrene.

27. The composition of Claim 26 in which the alkyd does not include said flexibilizing group, the amount of styrene is from about 58 to about 68 phr and the amount of said oligomer is from about 6 to about 16
5 phr.

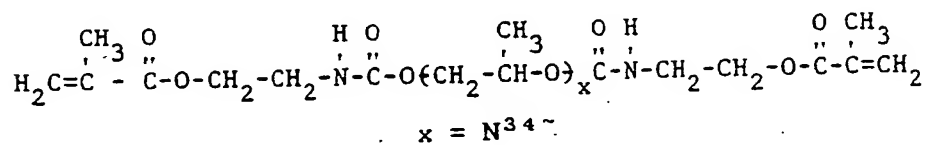
-76-

28. The composition of Claim 27 in which said terminal vinyl groups are derived from 3-hydroxypropyl acrylate and said oligomer has the statistical formula



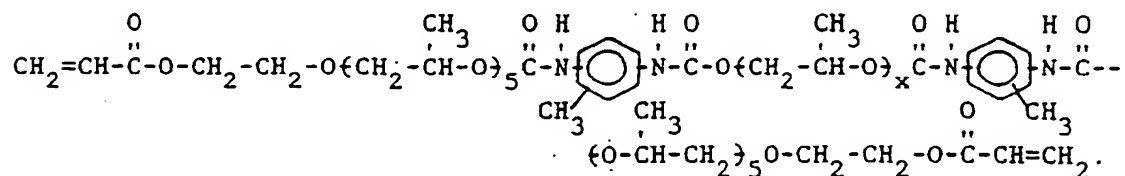
29. The composition of Claim 27 in which said oligomer is present in the amount of from about 6 to about 16 phr.

30. The composition of Claim 27 in which said terminal vinyl groups are derived from 2-isocyanatoethyl methacrylate and said oligomer has the statistical formula



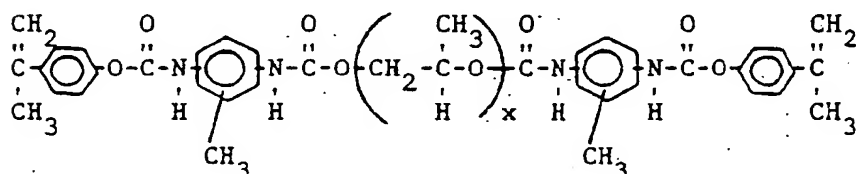
-77-

31. The composition of Claim 27 in which said terminal groups are derived from the mono(2-hydroxyethylacrylate)ether of pentapropyleneglycol-1,2 and said oligomer has the statistical formula



wherein $x = N^{34\sim}$

32. The composition of Claim 27 in which said terminal groups are derived from p-isopropenyl phenol and said oligomer has the statistical formula



where $x = N^{34\sim}$

33. The composition of Claim 25 in which said alkyd includes a flexibilizing group derived from a polyglycol which constitutes said polyol and the polyglycol-moiety in said oligomer is derived from an alkoxyated triol.

34. The composition of Claim 33 in which said polyol is also an alkoxyated triol.

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35. The composition of Claim 34 in which said flexibilizing group in said alkyd and said polyglycol moiety in said oligomer are both derived from the same alkoxyated triol.

36. The composition of Claim 35 in which said alkoxyated triol is a propoxyated glycerine.

37. The composition of Claim 33 in which said monomer is included and is styrene.

38. The composition of Claim 37 in which the amount of said styrene is from about 130 to about 150 phr.

39. The composition of Claim 33, 34, 35, 36, 37 or 38 in which the amount of said oligomer is within the range of from about 38 to about 60 phr.

40. The composition of Claim 1 in which said alkyd is Resin Oil-modified.

41. The composition of Claim 1 in which said oligomer is a reaction product of one molecular proportion of a polyglycol, about 1.7-2 molecular proportions of a monomeric diisocyanate and about 2 molecular proportions of a hydroxyalkyl acrylate or methacrylate.

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42. The composition of Claim 41 in which said polyglycol is a polypropylene glycol.

43. The composition of Claim 42 in which said polyglycol has a molecular weight of about 2000.

44. The cured composition of Claim 1, 6, 11, 12, 13, 23, 24, 25, 27, 29, 33, 34, 35, 36, 37, 38, 40, 41, 42 or 43.

AMENDED CLAIMS

[received by the International Bureau on 01 July 1985 (01.07.85);
original claims 1-44 replaced by new claims 1-24 (6 pages)]

1. A curable, flexibilized polyester composition comprising, in admixture:

- 5 a. an unsaturated polyester- and/or polyesteramide-
-alkyd having at least one polycycloalkenyl
end group and optionally including a polyglycol-
derived flexibilizing group, and
- 10 b. a flexibilizing, polyglycol moiety-comprising
urethane oligomer having (1) two or more
terminal groups, at least one of which is
vinyl-reactive, and (2) a weight average
molecular chain extension, calculated as
polystyrene, of less than 100Å,

15 the parts by weight of said oligomer per hundred parts
of said alkyd being such that the oligomer will not
phase out when said composition is cured and being
within the range of from 1 to 60 when the alkyd includes
said flexibilizing group but being less than 20 when
the latter group is not included in the alkyd.

2. The composition of Claim 1, including

from 25 to 400 parts by weight of a non-resinous, vinyl monomer per hundred parts of said alkyd.

3. The composition of Claim 1 or 2 in which said alkyd has two of said polycycloalkenyl end groups.

4. The composition of Claim 1, 2 or 3 in which at least two of the terminal groups in said oligomer are vinyl-reactive.

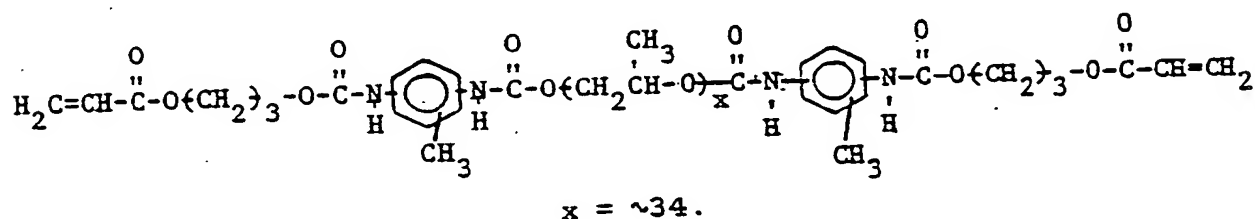
5. The composition of Claim 3 or 4 in which each of said terminal groups are deriveable from a vinyl compound independently selected from hydroxyethyl or hydroxypropyl esters of acrylic or methacrylic acid, mono acrylates or methacrylates of polyethylene-, polypropylene or polybutylene glycols, isocyanatoethyl- or 2-isocyanatopropyl esters of acrylic or methacrylic acid, vinyl or isopropenyl isocyanate or an isopropenyl phenol.

6. The composition of any one of Claims 1 to 5 in which said monomer is included and is styrene.

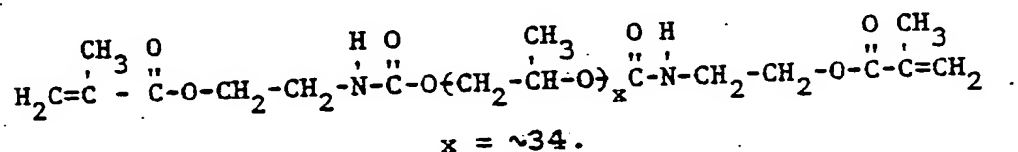
7. The composition of Claim 6 in which said alkyd does not include said flexibilizing group and the styrene is present in the amount of from 58 to 68 phr.

8. The composition of Claim 6 in which the alkyd includes said flexibilizing group and the styrene is present in the amount of from 130 to 150 phr.

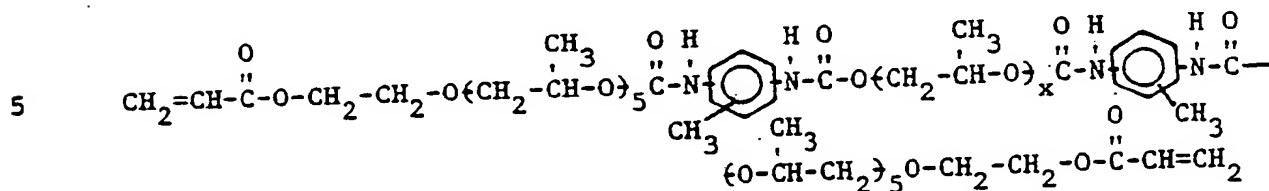
9. The composition of Claim 5, 7 or 8 in which said oligomer is deriveable from 3-hydroxypropylacrylate and has the statistical formula



10. The composition of Claim 5, 7 or 8 in which said oligomer is deriveable from 2-isocyanatoethylmethacrylate and has the statistical formula

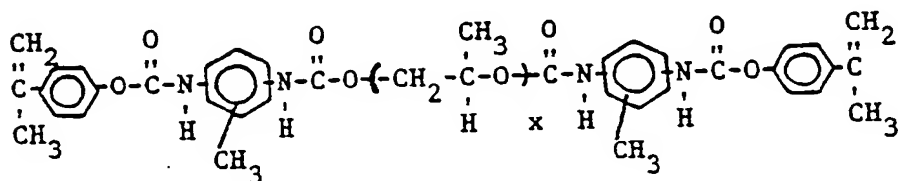


11. The composition of Claim 5, 7 or 8 in which said oligomer is deriveable from the mono(2-hydroxyethylacrylate)ether of pentapropyleneglycol-1,2 and has the statistical formula



wherein $x = \sim 34.$

12. The composition of Claim 5, 7 or 8 in which said oligomer is deriveable from p-isopropenyl phenol and has the statistical formula



where $x = \sim 34$.

13. The composition of Claim 7 in which the amount of said oligomer is from 6 to 16 phr.

14. The composition of Claim 8 in which the amount of said oligomer is from 41 to 59 phr.

15. The composition of any one of Claims 1 to 12 in which said alkyd is the reaction product of

(a) dicyclopentadiene or a concentrate thereof, maleic acid and, optionally, water,

5 or

(b) dicyclopentadiene or a concentrate thereof, water, and maleic anhydride or a mixture thereof with maleic acid,

with

10

a polyol and, optionally, a diamine.

16. The composition of Claim 15 in which said alkyd includes a flexibilizing group derived from a polyglycol which constitutes said polyol and the polyglycol-moiety in said oligomer is derived from an alkoxyated triol.

5

17. The composition of Claim 16 in which said polyol is also an alkoxyated triol.

18. The composition of Claim 17 in which said flexibilizing group in said alkyd and said polyglycol moiety in said oligomer are both derived from the same alkoxyated triol.

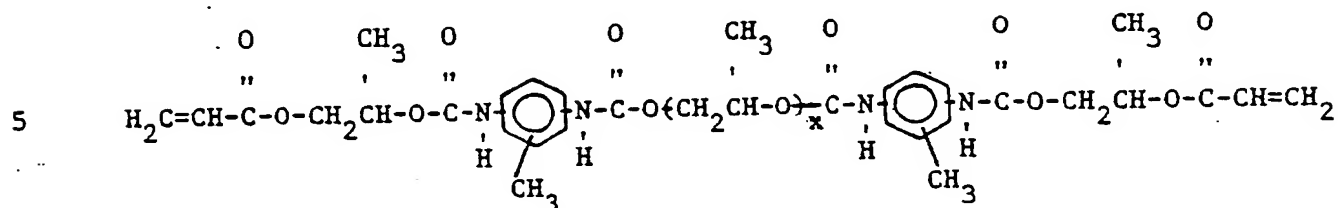
19. The composition of Claim 18 in which said alkoxyated triol is a propoxyated glycerine.

20. The composition of Claim any one of Claims 16 to 19 in which the amount of said oligomer is within the range of from 38 to 60 phr.

21. The composition of Claim 1 in which said alkyd is Resin Oil-modified.

22. The composition of Claim 1 in which said oligomer is a reaction product of one molecular proportion of a polyglycol, about 1.7-2 molecular proportions of a monomeric diisocyanate and about 2 molecular proportions of a hydroxyalkyl acrylate or methacrylate, and wherein said polyglycol is a polypropylene glycol, having a molecular weight of about 2000.

23. The composition of Claim 5, in which said terminal vinyl groups are derived from 2-hydroxypropyl acrylate and said oligomer has the statistical formula



$$x = \sim 34.$$

24. A cured composition of any one of the preceding claims.

INTERNATIONAL SEARCH REPORT

International Application No PCT/US85/ 00635

I. CLASSIFICATION OF SUBJECT MATTER (If several classification symbols apply, indicate all) ³		
According to International Patent Classification (IPC) or to both National Classification and IPC INT. CL. ³ C08F 299/04, 06; C08L 67/06, 77/12 U.S. CL. 525/28, 421		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
U.S.	525/28, 421, 440, 920	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁶		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴		
Category ⁵	Citation of Document, ¹⁵ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
Y	US, A, 4,421,894 PUBLISHED 20 DECEMBER 1983 O'CONNOR	1-44
Y	US, A, 4,413,072 PUBLISHED 01 NOVEMBER 1983 HESS	1-44
Y	US, A, 4,410,686 PUBLISHED 18 OCTOBER 1983 HEFNER	1-44
Y	US, A, 4,409,371 PUBLISHED 11 OCTOBER 1983 HEFNER	1-44
Y	US, A, 4,390,662 PUBLISHED 28 JUNE 1983 ANDO	1-44
Y	US, A, 4,360,653 PUBLISHED 23 NOVEMBER 1982 STEVENS	8, 15, 19, 30
Y	US, A, 4,233,432 PUBLISHED 11 NOVEMBER 1980 CURTIS	1-44
Y	US, A, 4,167,542 PUBLISHED 11 SEPTEMBER 1979 NELSON	1-44
Y	US, A, 3,891,523 PUBLISHED 24 JUNE 1975 HISAMATSU	1-44
A	US, A, 3,644,569 PUBLISHED 22 FEBRUARY 1972 PIETSCHE	1-44
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>¹⁵ Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 45%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"&" document member of the same patent family</p> </div> </div>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ¹		Date of Mailing of this International Search Report ¹
03 MAY 1985		24 MAY 1985
International Searching Authority ¹		Signature of Authorized Officer ¹⁰
ISA/US		Patricia Short PATRICIA SHORT

III. DOCUMENTS CONSIDERED TO BE RELEVANT (CONTINUED FROM THE SECOND SHEET)

Category *	Citation of Document, ¹⁸ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No ¹⁸
Y	US, A, 3,448,172 PUBLISHED 03 JUNE 1969 DAMUSIS	1-44
A	US, A, 3,297,745 PUBLISHED 10 JANUARY 1967 FEKETE	1-44
Y	US, A, 2,970,984 PUBLISHED 07 FEBRUARY 1961 D'ALELIO	10, 17, 21, 32
Y	JP, A, 53-088,094 PUBLISHED 03 AUGUST 1978 SUMITOMO	10, 17, 21, 32